AXMINSTER Trade SERIES

Code: 501209

WS1000TA
Spindle Moulder

Axminster Tool Centre,
Unit 10 Weycroft Avenue, Axminster, Devon EX13 5PH

www.axminster.co.uk

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Declaration of Conformity

Copied from CE Certificate

The undersigned G. Reimann, authorised by

Laizhou Planet Machinery Co., Ltd. Yutai West Street Laizhou, Shandong 261400 P.R. China

Model number MX5110A

manufactured by Laizhou Planet Machinery Co. is in compliance with the following standards or standardisation documents in accordance with Council Directives

2006/42/EC
2006/95/EC

Warning

The symbols below advise that you follow the correct safety procedures when using this machine.

Fully read manual and safety instructions before use

Ear protection should be worn

Eye protection should be worn

Dust mask should be worn

HAZARD
Motor gets hot

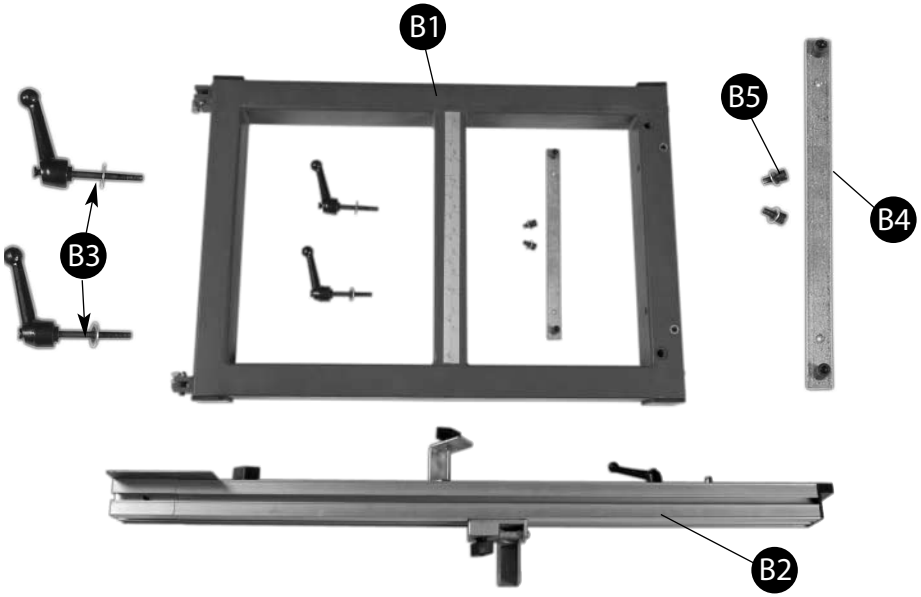
Quantity	Item		Model Number
1 off	Spindle Moulder	**A**	MX5110A
Support Table Assembly		**C**	
1 off	Support Table	C1	
2 off	Lift & Shift Handles with Washers (M8 Thread)	C2	
1 off	Pre-drilled Steel Plate	C3	
Spindle Guard Assembly		**D**	
1 off	Spindle Guard with Adjustable Fence	D1	
2 off	Lift & Shift Handles with washers M8 x 140mm	D2	
1 off	Guide Assembly Mounting Bracket	D3	
Guide Assembly		**E**	
1 off	Guide Arm	E1	
1 off	M8 Clamping Knob	E2	
1 off	Lift & Shift Handles with Washers (M8 Thread)	E3	
1 off	Guide Roller Assembly	E4	
1 off	Anti-Kickback Assembly	E5	
Mitre Fence Work Clamp Assembly	**F**		
1 off	Mitre Fence Casting with Fence	**F1**	
1 off	Work Clamp	F2	
1 off	Pre-drilled Metal Plate with Pointer	F3	
1 off	M10 Clamping Knob with Washer	F4	
1 off	Lift & Shift Handle with Washer (M10 Thread)	F5	
1 off	10mm Allen Key & 4mm Double Ended Allen Key		
1 off	Instruction Manual		

Optional Accessories

Tenon Plate (Order No: 950506)

Sliding Table Extension Assembly (Order No:950505)		**B**
1 off	Extension Table	B1
1 off	Extension Table Fence (Adjustable)	B2
2 off	Lift & Shift Handles with Washers (M6 Thread)	B3
1 off	Pre-drilled Steel/Pin Plate	B4
2 off	M6 x 11mm Caphead screws & washers	B5
1 off	Pivot Arm with four bolts & washers	B6
1 off	Extension Table Support Rod	B7

B



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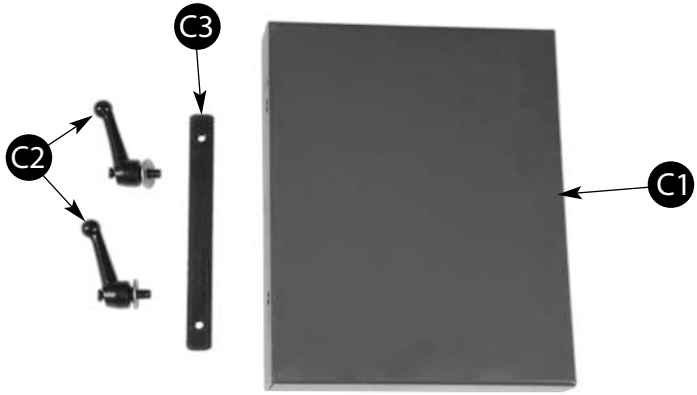

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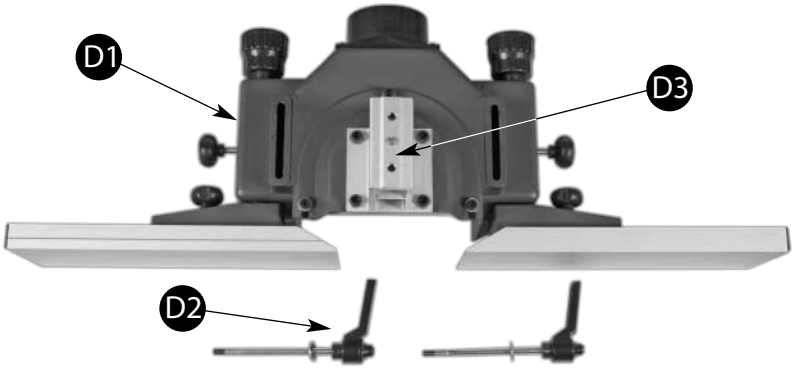

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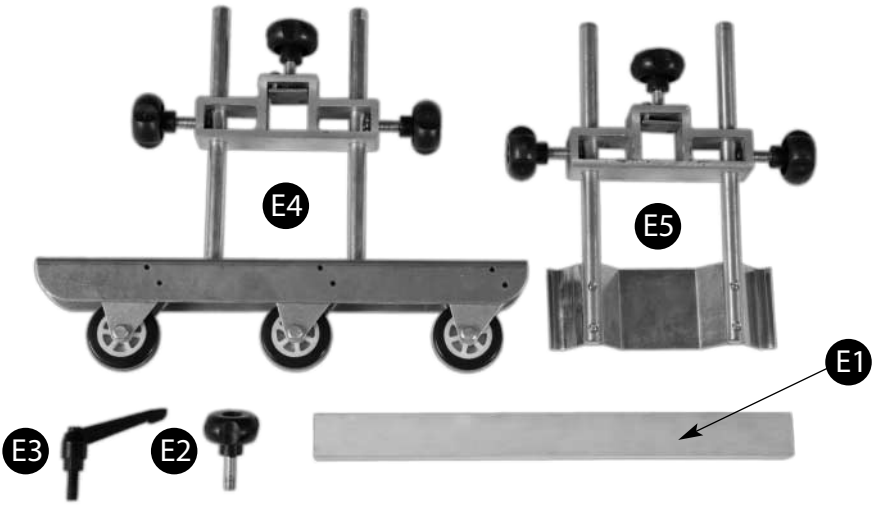

What's in the Box

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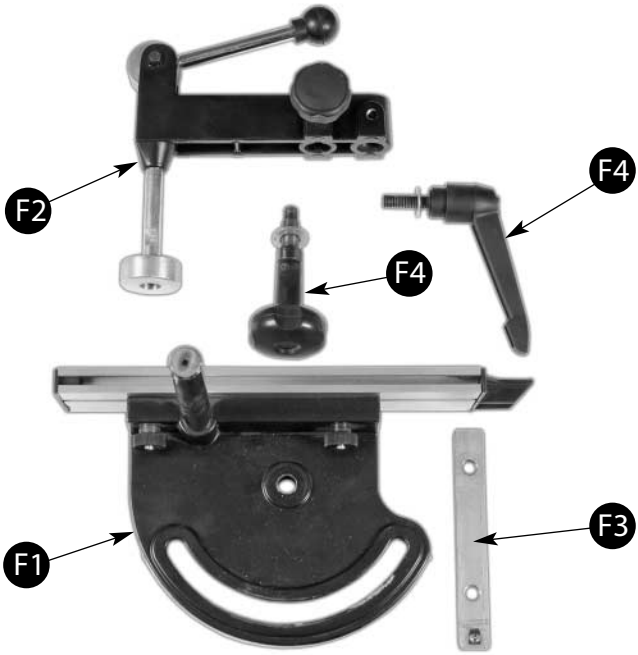


General Instructions for 230V Machines

Good Working Practices/ Safety

The following suggestions will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.

WARNING! KEEP TOOLS AND EQUIPMENT OUT OF THE REACH OF YOUNG CHILDREN!

Mains Powered Tools

Primary Precautions

This machine is supplied with a moulded 16 Amp. Plug and 3 core power cable. Before using the tool inspect the cable and the plug to make sure that neither are damaged. If any damage is visible have the tool inspected/repaired by a suitably qualified person. If it is necessary to replace the plug, it is preferable to use an 'unbreakable' type that will resist damage on site. Only use a 16 Amp plug, and make sure the cable clamp is tightened securely. Fuse as required. If extension leads are to be used, carry out the same safety checks on them, and ensure that they are correctly rated to safely supply the current that is required for your machine.

Work Place/Environment

The machine is not designed for sub-aqua operation, do not use when or where it is liable to get wet. Do not use 230V powered tools anywhere within a site area that is flooded and do not trail extension cables across wet areas.

Keep the machine clean; it will enable you to more easily see any damage that may have occurred. Do not use any solvents or cleaners, as these may cause damage to any plastic parts or to the electrical components.

KEEP THE WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS.

It is good practice to leave the machine unplugged until work is about to commence, also make sure to unplug the machine when it is not in use, or unattended. Always disconnect by pulling on the plug body and not the cable. Once you are ready to commence work, remove any tools used in the setting operations (if any) and place safely out of the way. Re-connect the machine.

Carry out a final check e.g. check the cutting tool is securely tightened in the machine, check you have the correct speed and function set, check that the power cable will not 'snag' etc. Make sure you are comfortable before you start work, balanced, not reaching etc.

If the work you are carrying out is liable to generate dust or chips, wear the appropriate safety clothing, goggles, gloves, masks etc. If the work operation appears to be excessively noisy, wear ear-defenders. If you wear your hair in a long style, wearing a cap, safety helmet, hairnet, even a sweatband, will minimise the possibility of your hair being caught up in the rotating parts of the machine, likewise, consideration should be given to the removal of rings and wristwatches, if these are liable to be a 'snag' hazard. Consideration should also be given to non-slip footwear, etc. If you are allowing another person to use the machine, ensure that they are suitably qualified to use it. Check that cutters are the correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine. Above all, **OBSERVE....** make sure you know what is happening around you, and **USE YOUR COMMON SENSE.**

DO NOT WORK WITH CUTTING OR BORING MACHINE OF ANY DESCRIPTION IF YOU ARE TIRED, YOUR ATTENTION IS WANDERING OR YOU ARE BEING SUBJECTED TO DISTRACTION.

DO NOT USE THIS MACHINE WITHIN THE DESIGNATED SAFETY AREAS OF FLAMMABLE LIQUID STORES OR IN AREAS WHERE THERE MAY BE VOLATILE GASES.

Specific Safety Precautions

Authorised Use

This machine is designed for shaping wood and wood derived materials.

Machining of other materials is not permitted and may be carried out in specific cases only after consulting with the manufacturer.

The proper use also includes compliance with the operating and maintenance instructions given in this manual.

The machine must be operated only by persons familiar with its operation and maintenance and who are familiar with its hazards.

The required minimum age must be observed.

The machine must only be used in a technically perfect condition.

When working on the machine, all safety mechanisms and covers must be in operation.
In addition to the safety requirements contained in these operating instructions and your country's applicable regulations, you should observe the generally recognized technical rules concerning the operation of woodworking machines.

Any other use exceeds authorisation.

In the event of unauthorised use of the machine, the manufacturer renounces all liability and the responsibility is transferred exclusively to the operator.

Specific Safety Precautions

General Safety Notes

Woodworking machines can be dangerous if not used properly. Therefore the appropriate general technical rules as well as the following notes must be observed.

Read and understand the entire instruction manual before attempting assembly or operation.

Keep these operating instructions close by the machine, protected from dirt and humidity, and pass them over to the new owner if you part with the tool.

No changes to the machine may be made.

Daily inspect the function and existence of the safety appliances before you start the machine.

Remove all loose clothing and enclose long hair.

Before operating the machine, remove tie, rings, watches, other jewellery, and roll up sleeves above elbows.

Wear safety shoes; never wear leisure shoes or sandals.

Always wear the approved working outfit.

Do not wear gloves while operating the machine.

For the safe handling of cutting tools wear work gloves.

Control the stopping time of the machine, it may not exceed 10 seconds.

Remove cut and jammed workpieces only when the machine is at a complete standstill and motor is turned off.

Install the machine so that there is sufficient space for safe operation and workpiece handling.

Keep work area well lit.

Specifications

Model	WS1000TA
Product Code	501209
Rating	Trade
Power	2.8kW (230V, 1ph)
Spindle Travel	100mm
Spindle Diameter	30mm
Max Spindle Projection above Table	100mm
Max Tooling Diameter Above Table	200mm
Max Tooling Diameter Below Table	180mm
Table Height	900mm
Table Size	1,000 x 360mm
Min Extraction Airflow Required	1,000m³/hr
Dust Extraction Outlet	100mm x 2
Overall L x W x H	1,010 x 690 x 900mm
Weight	218kg

PLEASE NOTE. Some of this assembly procedure is best accomplished by two persons. Although the tasks are not impossible, some of the items are heavy and awkward, and a mishandling error could cause injury. Please think about what you are doing, your capabilities and your personal safety.

Unpack all the boxes and check all the components against the "What's in the Boxes' List. If any parts or components are missing, please contact our customer services department using the procedures and telephone numbers listed in our catalogue, and you will be dealt with quickly and efficiently.

Having unpacked the boxes, (please dispose of any unwanted packaging responsibly), put the parts and components whereby they are readily to hand. Break down the main box by knocking the sides away (be careful of exposed nails etc.), but leave the machine sitting on its pallet. Remove the protective grease film that is coating all the unpainted parts of the machine.

Use a proprietary de-greasing agent or paraffin et al. Unfortunately, this cleaning process is always a bit 'mucky' especially if you tackle the job with a high level of enthusiasm. You are advised to wear overalls or coveralls etc., during the process. After cleaning, especially if you used paraffin, lightly coat the exposed metal surfaces to prevent any rusting.

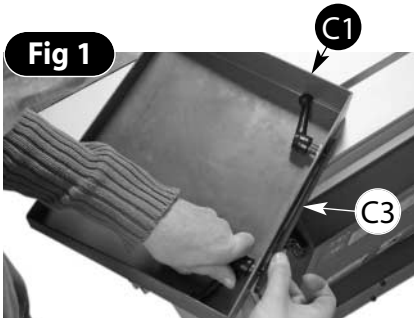
Note: The WS1000TA spindle moulder comes 95% assembled, in order to reduce the footprint of the machine for packaging, several items are dismounted from the machine and need to be re-affixed.

Step 1

Support Table Assembly

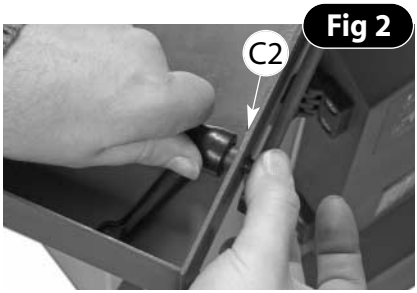
Locate the support table (**C1**), the two lift and shift handles with M8 washer **(C2)** & the pre-drilled steel plate **(C3)**. Line up the pre-drilled holes in the steel plate **(C3)** with holes in the bench casting **(C1)** and screw the two lift and shift handles **(C2)** through. Note: leave at least a 3mm gap between the plate **(C3)** & the support table **(C1)** for the next stage (See figs 1 & 2).

Fig 1



Screw the two lift and shift handles **C2** through the both **C1** & **C3**

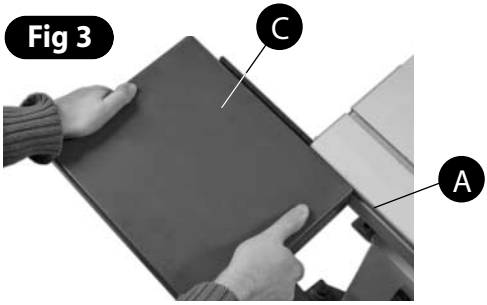
Fig 2



Keep at lest a 3mm gap between the steel plate **C3** and support table **C1**

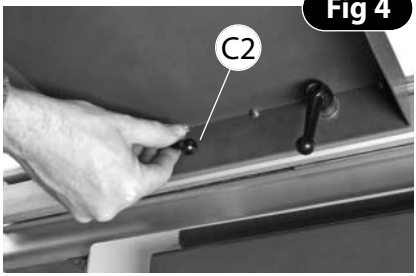
Line up the edge of the steel plate **(C3)** with the 'T' slot machined into the sliding table **A** see fig 3. Slide the support table assembly **(C)** onto the sliding table & position it to the far side. Tighten the two lift and shift handles **(C2)** to clamp the assembly in position (See fig 4).

Fig 3



Slide the table assembly **C1** onto the sliding table **A**

Fig 4



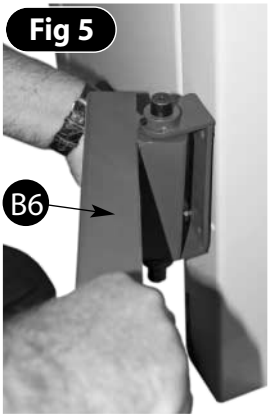
Clamp the table in position by tightening the two lift and shift handles **C2**

Step 2

Sliding Table Extention Assembly (Optional Accessory Order No: 950505)

Locate the pivot arm **(B6)** with the four bolts & washers, line the holes in the mounting bracket with pre-drilled holes to the side of the spindle moulder **(A)** & secure using the bolts and washers (See figs 5-6). Locate the extention table support rod **(B7)**, slide the support rod **(B7)** through the pre-drilled hole in the pivot arm **(B6)** and secure using the nuts & washers (See figs 7-8).

Fig 5



Line up pivot arm bracket to the side of the machine

Locate the extention table **(B1)**, extention table fence **(B2)**, lift and shift handles with M6 washers **(B3)** & the pre-drilled steel pin plate **(B4)**.

Slide the steel pin plate into the machined 'T' slot to the left hand side of the sliding table (See fig 9).

Pull out the extention table support arm **(B6)** see figs 10 and 11, offer up the machined slots in the table **(B1)** with the pins **(B4)**, see figs 12 and 13, locate the two lift and shift handles **(B3)** and screw them through the pre-drilled holes in the table **(B1)** into the pre-drilled steel pin plate **(B4)**, see fig 14. Tighten the lift and shift handles **(B3)**.

Fig 6

Using a spanner, tighten the five bolts

 Continues Over....

Fig 7

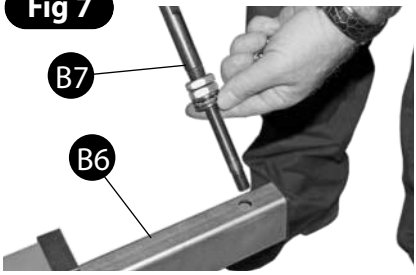


Fig 8

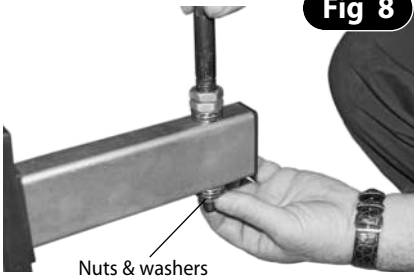


Fig 9

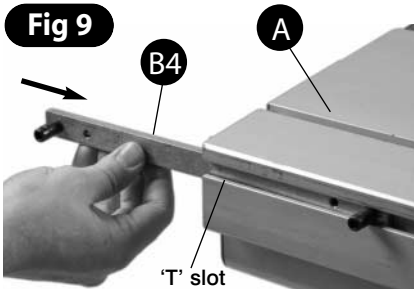


Fig 10

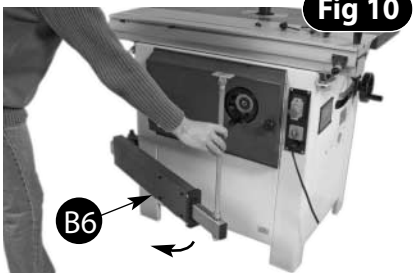
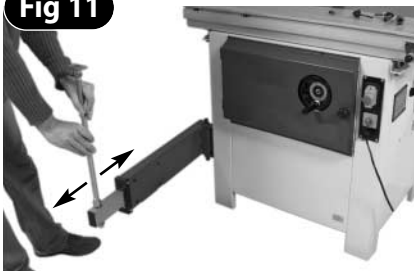


Fig 11



Machined slots

B1

Fig 12

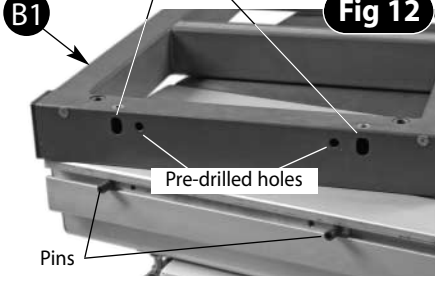


Fig 13

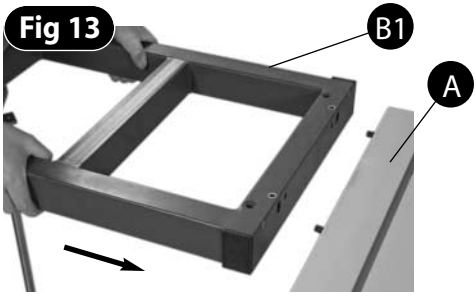


Fig 14

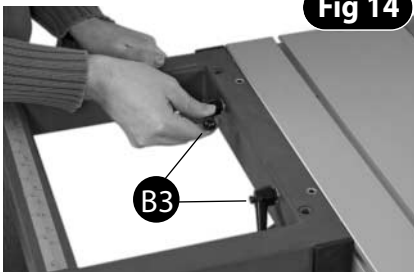


Fig 15

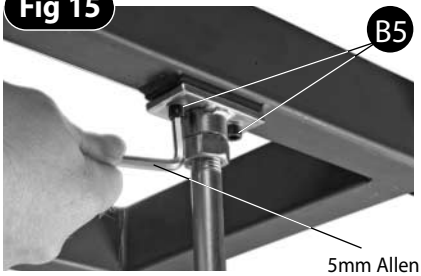
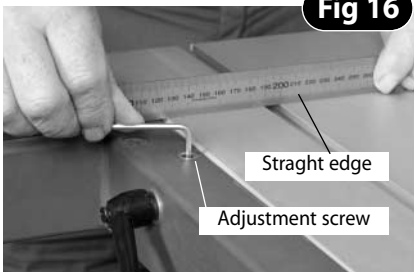


Fig 16



Locate the two M6 x 11mm caphead screws **(B5)**, line up the extention table support rod **(B7)** bracket with the pre-drilled holes in the extention table (B1), using the two M6 caphead screws and a 5mm allen key secure the support rod **(B7)** to the table **(B1)** (See fig 15). On top of the extention table there are two adjustment grub screws, using a straight edge adjust the screws using a 4mm allen key until both sliding and extention tables are level (See fig 16). (Note: Turn clockwise to raise the extention table, counterclockwise to lower it).

Fig 17

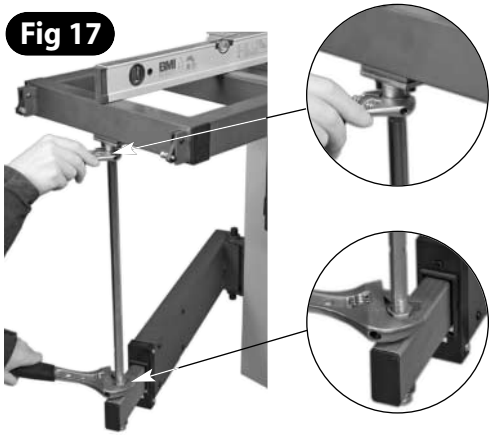


Fig 18

Place a level on the extention table **(B1)** and using two spanners adjust the four nuts on the support rod **(B7)** until the extention table **(B1)** is level (See figs 17 and 18)

Lift up the left 90˚ degree stop, see fig 19, locate the extention table fence assembly **(B2)**, lower the fence assembly onto the table casting **(B1)** making sure the pin beneath the fence inserts into the pre-drilled hole on top of the table casting **(B1)**, see figs 20 and 21. Push the fence up-against the 90˚ stop, position the angle bracket **(a)** up-against the table casting **B1** and turning butterfly knob clamps the fence **(B2)** to the table casting **(B1)** (See fig 22). Lastly tighten the lift and shift handle **(b)** to prevent the pin from moving (See figs 22).

Note: The fence (B2) can be mounted to the opposite side of the table casting (B1) in the same way as described above.

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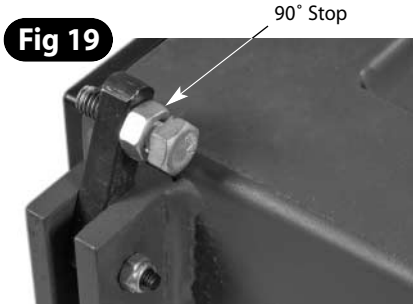
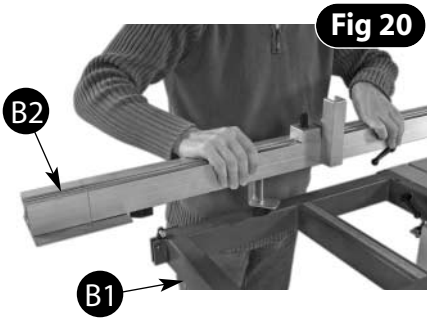
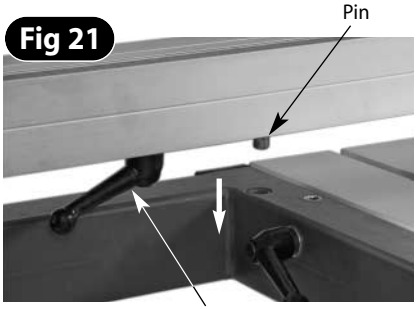
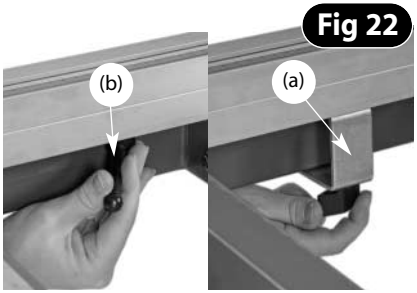






Lift & shift handle pin lock



Turning the handle to lock pin

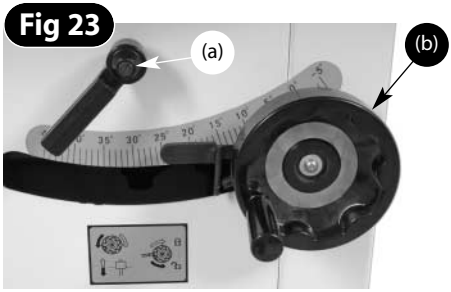
Turn butterfly knob to lock the fence

Step 3

Spindle Guard Assembly

Locate the spindle guard **(D1)** and the two M8 x 140mm lift & shift handles with washers **(D2)**. Raise the spindle to the maximum height by unlocking the spindle moulder rise/fall locking handle **(a)** and turning the spindle moulder rise/fall wheel clockwise **(b)** then lock in place (See figs 23-24).

Remove the circular rings from the work table and place aside, see fig 25, Lower the spindle guard **(D1)** onto the work surface & line up the machined slots in the guard casting **(D1)** with the two pre-drilled holes on either side of the spindle (See figs 24-26). Put to hand the lift & shift handles **(D2)**, slide each one through the machined slot in the guard casting **(D1)** and screw them into the pre-drilled holes on the spindle table, locking the guard **(D1)** in position (See figs 27-28).



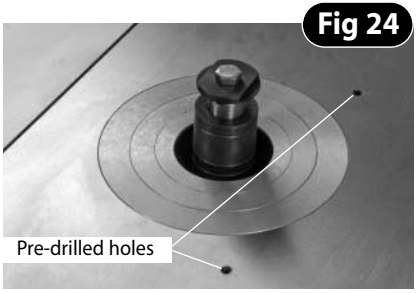


Fig 25

Fig 26

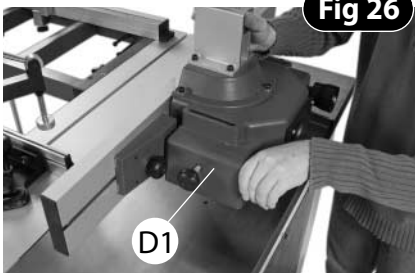


Fig 27

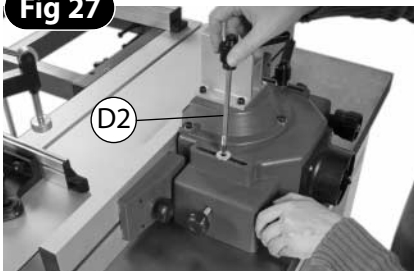
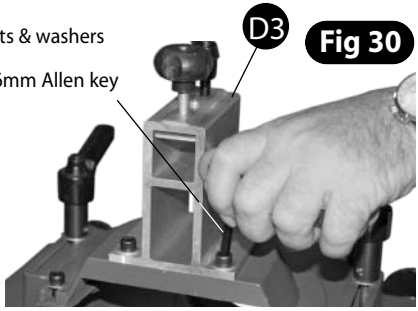


Fig 28

Locate the guide assembly mounting bracket **(D3)**, using a 6mm allen key remove the four caphead bolts & washers on top of the spindle guard **(D1)**, place safely aside (See fig 29). Lower the guide assembly mounting bracket **(D3)** on top of the spindle guard & line up the four pre-drilled holes, replace the caphead bolts & washers you removed earlier and tighten (See fig 30) **(DO NOT OVERTIGHTEN)**.

Fig 29

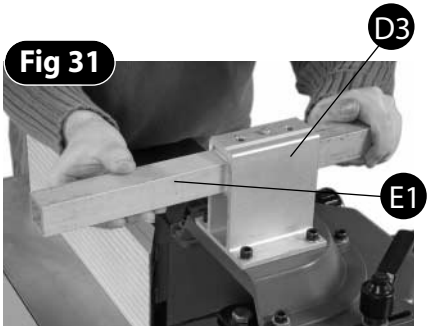
Fig 30



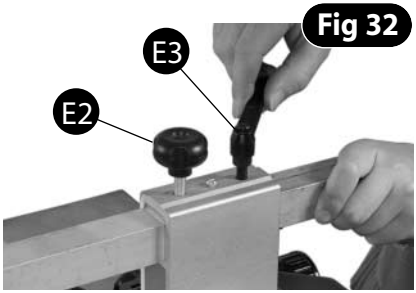
Step 4

Guide Assembly

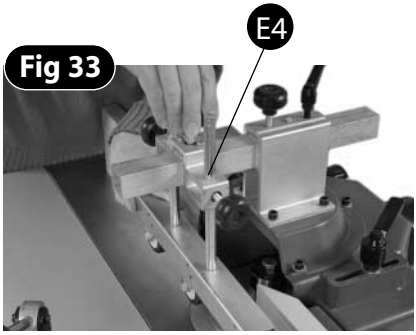
Locate the guide arm **(E1)** and slide it through the mounting bracket **(D3)**, with two thirds extending out for the front of the guard, clamp in place using the M8 clamping knob **(E2)** and lift and shift handle **(E3)** (See figs 31-32). Locate the feeder roller assembly **(E4)** and slide it onto the guide arm **(E1)**, clamp in place using the clamping knob (See fig 33). Locate the anti-kickback assembly **(E5)** and repeat as before (See fig 34). **(NOTE: Make sure metal wave plate is facing inwards)**



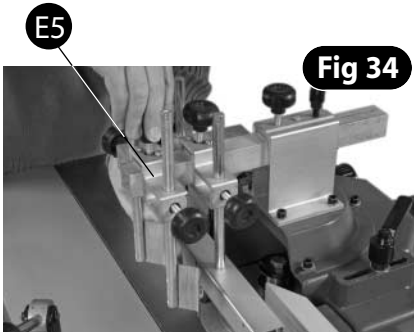
Slide the guide arm **(E1)** through the mounting bracket **(D3)**



Clamp the guide arm with the clamping knob **(E2)** and lift and shift handle **(E3)**



Slide on the guide roller assembly **(E4)** and clamp in position



Slide the anti-kickback assembly **(E5)** and clamp in position

Continues Over....

Step 5

Mitre Fence Work Clamp Assembly

Locate the pre-drilled metal plate **(F3)** & slot it into the machined 'T' slot in the sliding table (See figs 35-36). Lower the mitre fence casting **(F1)** on top of the metal plate **(F3)**, line up the machined slot & pre-drilled hole in the mitre fence casting with the holes in the metal plate, see fig 37, locate the M10 clamping knob **(F4)** with washer & screw it through the hole in the casting into the metal plate **(F3)** (See fig 38). Locate the lift and shift handle **(F5)** and screw it through the machined slot into the remaining pre-drilled hole and lightly tighten (See fig 39). Lastly locate the work clamp **(F2)** and slide it onto the steel rod, clamp in place by tightening the clamping knob (See fig 40). **(DO NOT OVERTIGHTEN)**

'T' Slot

Fig 35

Fig 36

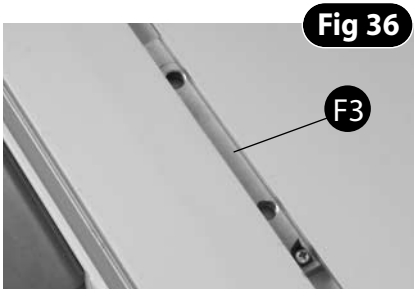


Fig 37

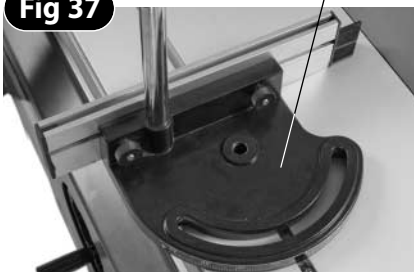
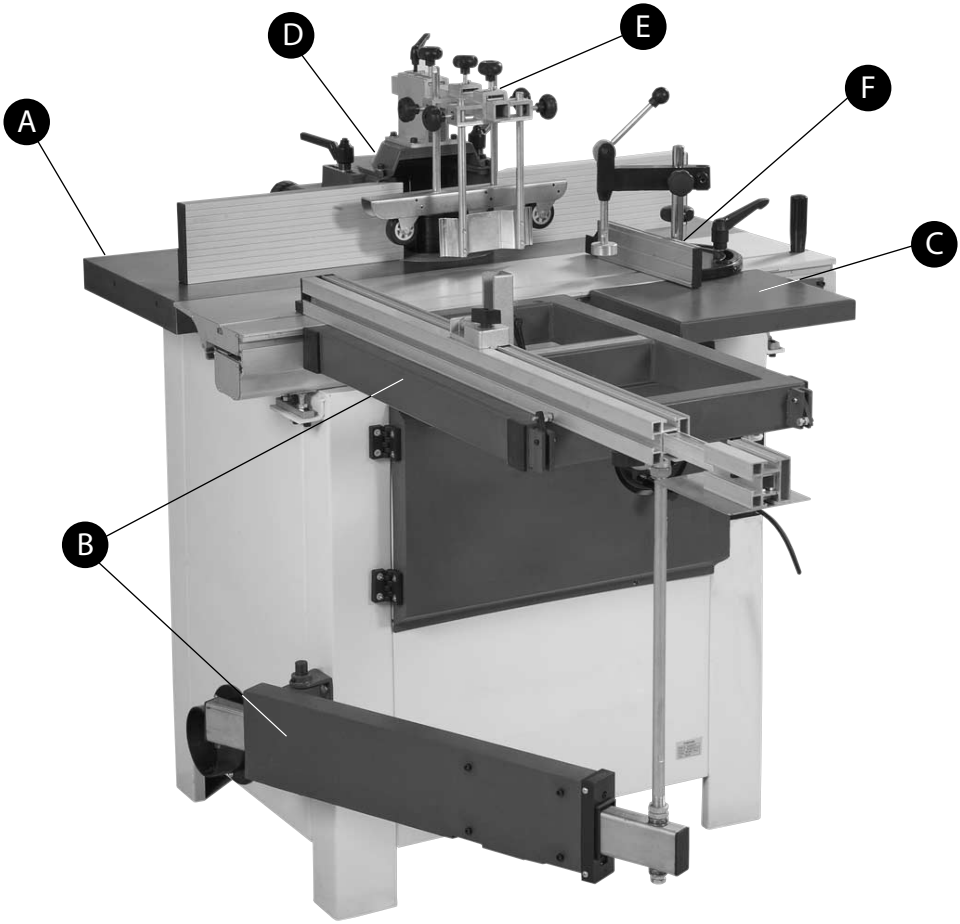


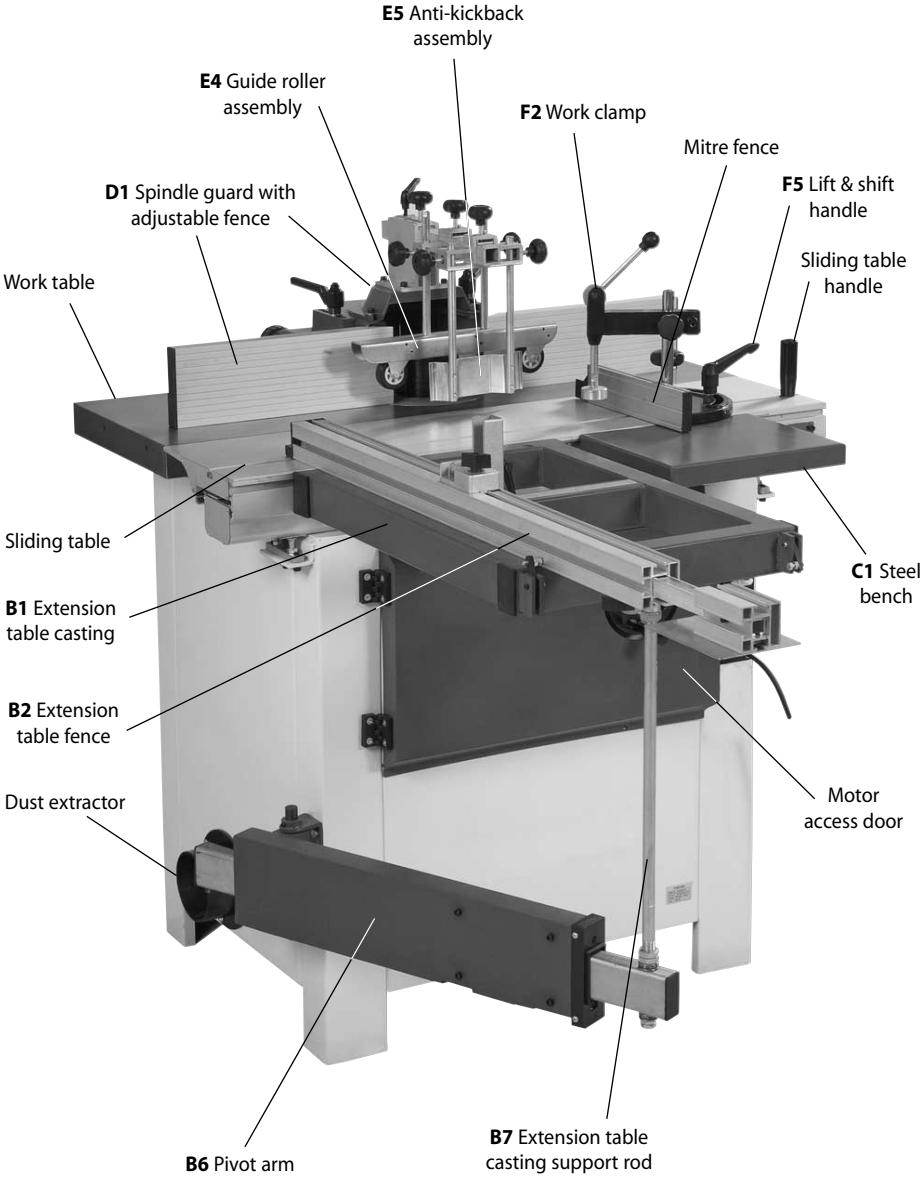
Fig 38

Fig 39

Fig 40



A Spindle Moulder	**D** Spindle Guard Assembly
B Sliding Table Extention Assembly Optional	**E** Guide Assembly
Accessory (Order No: 950505)	**F** Mitre Fence Work Clamp Assembly
C Sliding Bench Assembly	


E5 Anti-kickback assembly
E4 Guide roller assembly
F2 Work clamp
Mitre fence
F5 Lift & shift handle
D1 Spindle guard with adjustable fence
Sliding table handle
Work table
Sliding table
C1 Steel bench
B1 Extension table casting
B2 Extension table fence
Dust extractor
Motor access door
B6 Pivot arm
B7 Extension table casting support rod

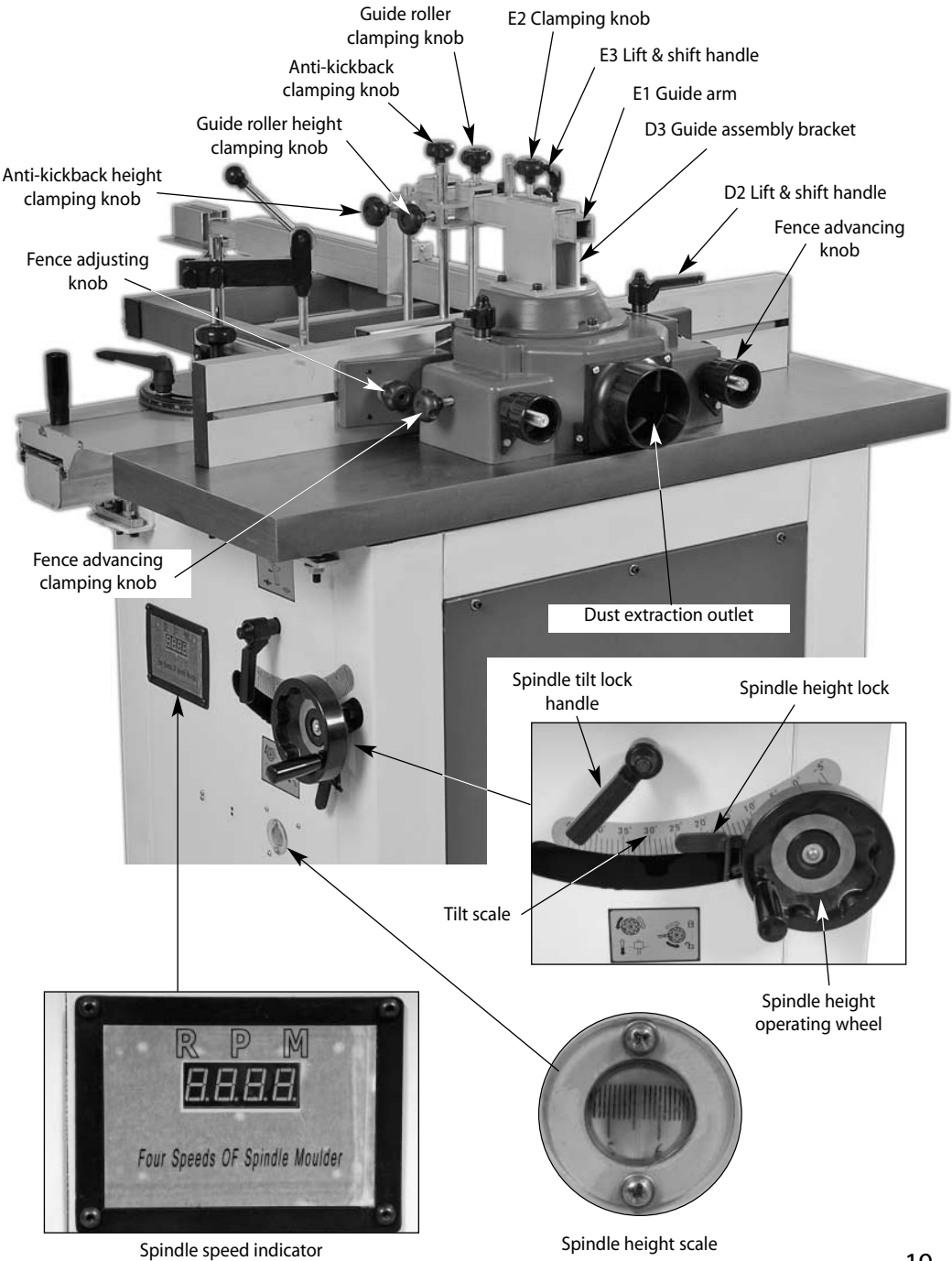
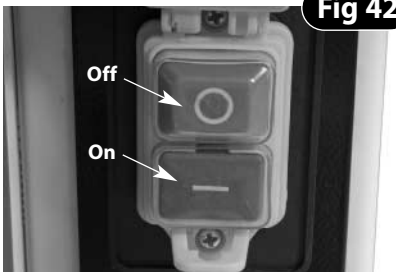

Guide roller clamping knob
E2 Clamping knob
E3 Lift & shift handle
Anti-kickback clamping knob
E1 Guide arm
Guide roller height clamping knob
D3 Guide assembly bracket
Anti-kickback height clamping knob
D2 Lift & shift handle
Fence advancing knob
Fence adjusting knob
Fence advancing clamping knob
Dust extraction outlet
Spindle tilt lock handle
Spindle height lock
Tilt scale
Spindle height operating wheel
R P M
Four Speeds OF Spindle Moulder
Spindle speed indicator
Spindle height scale

Fig 41

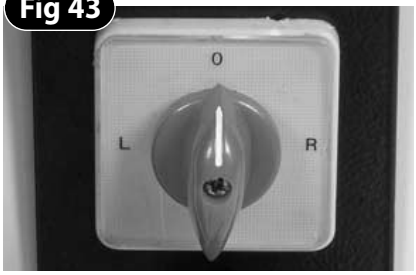
Spindle moulder control panel

Fig 42



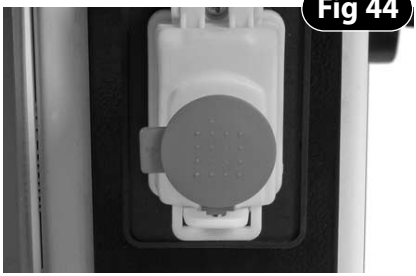
NVR ON/OFF switch

Fig 43



Reversing selector switch

Fig 44



Emergency stop shroud, slap the shroud down to stop the machine.

NOTE: The machine is equipped with a FORWARD/REVERSE switch as shown in figure 43. You will find many instances that it is necessary to flip the cutter over and reverse the cutter rotation.

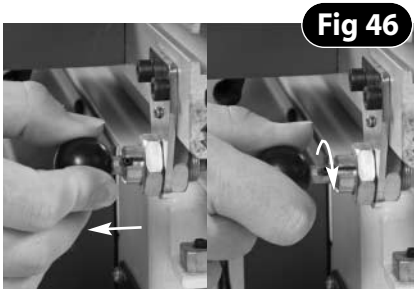
CAUTION: BEFORE TURNING THE SELECTOR SWITCH, MAKE SURE THE MACHINE IS AT A COMPLETE STOP!

NOTE: Turning the reversing selector switch to the (L) position the motor will run in a forward motion & the spindle will turn counter-clockwise. Turning the selector switch to the (R) position the motor will run reverse & the spindle will turn clockwise (See fig 43).

Fig 45

Sliding table locking knob, locked in the out position

Fig 46

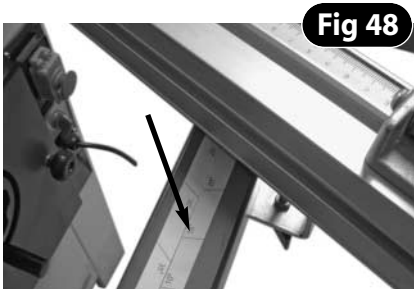


Pull the locking knob & twist

Fig 47

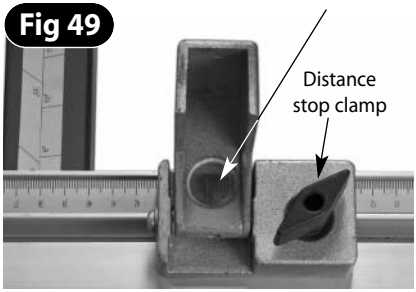
The extension table fence set to 45˚

Fig 48



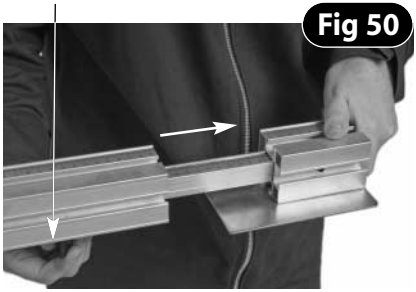
Extension table angle scale

Fig 49



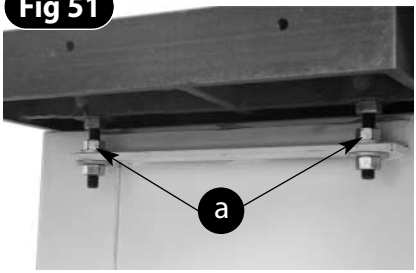
Distance stop assembly

Fig 50



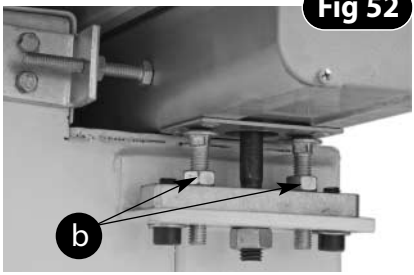
Telescopic extension assembly

Fig 51



Spindle moulder table height
adjusting nuts (a)

Fig 52

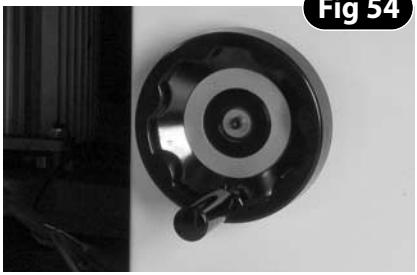


Sliding table height adjusting nuts (b)

Fig 53

Extension table 90˚ stop

Fig 54



Spindle tilt operating handle, located
to the front of the machine

Setting the fence

The fence is a two piece adjusting system. Each fence is independently adjustable to compensate for different cutting thicknesses.

Make sure the fence is square to the work surface, place a 90˚ square up against the fence and check it is perpendicular to the work surface. If it is not, turn the fence adjusting knob **(a)** until it is correct (See figs 55 and 56).

Place a straight edge up-against the fence, loosen the fence advancing clamping knobs & turn the fence advancing knobs **(b)** until both fences are aligned (See figs 57 & 58).

Fig 55

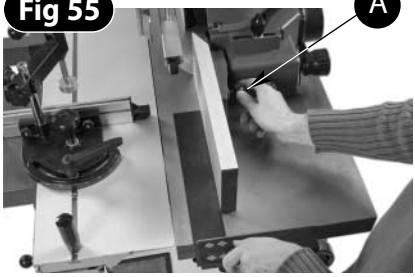
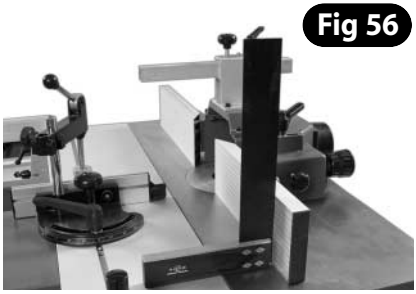
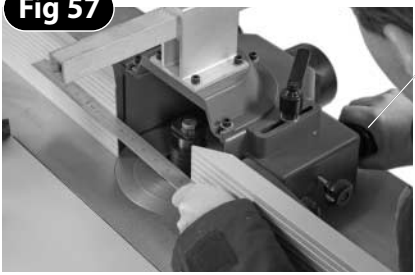


Fig 56



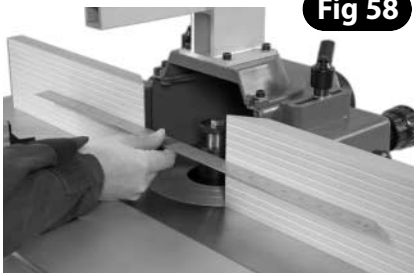
Place a 90˚square up against the fence and check it is perpendicular

Fig 57



Adjust the advancing knobs (b) until both fences are aligned

Fig 58

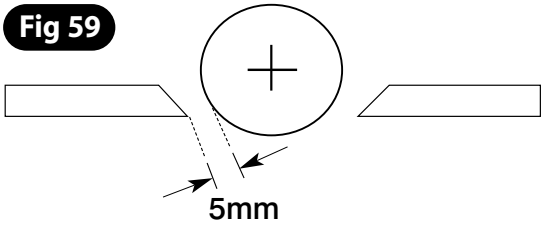


Place a straight edge up-against the fences and check they are aligned

Adjust the position of the fence assembly to give both the required cutter protrusion and adequate clearance between the cutter and the fence. Close up the aluminum fences to give approximately 5mm clearance around the cutter (see fig 59).

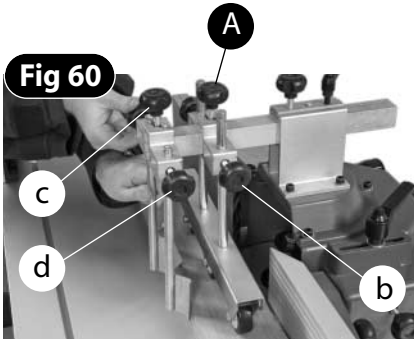
The fence is used to guide small workpieces through the cutter without them being trapped between the fence and the cutter. The dust extraction hose is connected to the aperture at the rear of the fence casting.

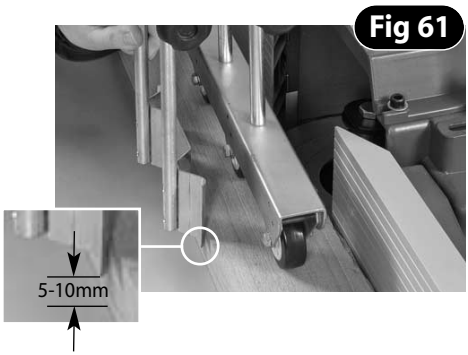
Before starting work, carefully check that the cutter can rotate freely without fouling the inside of the guard and that the guard is clamped firmly in place.



Adjusting the feeder roller & ant-kickback assembly

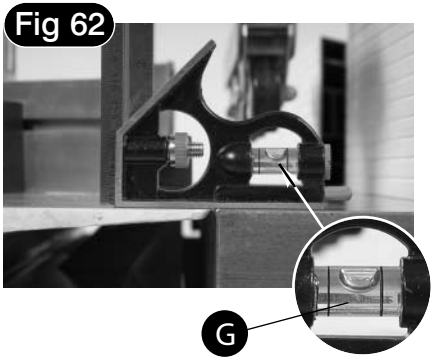
Loosen the feeder roller clamping knobs (**a** and **b**) & move the feeder roller to the centre of the workpiece, tighten the clamping knobs. Undo the anti-kickback clamping knobs (**c** and **d**) and move the assembly near the workpiece, tighten the clamping knob **(c)**, raise the assembly so the steel plate is about 5-10mm above the work table (See figs 60 & 61).

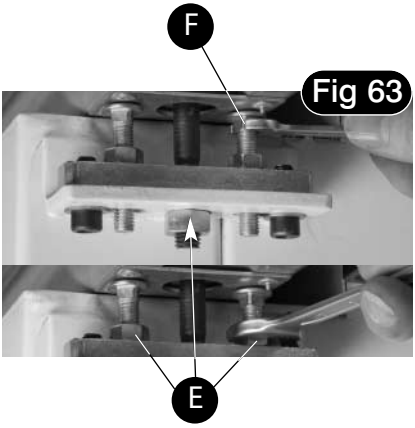




Leveling the sliding table

Place a level between the sliding table & work table & check that both tables are level. If not loosen the three nuts (e) beneath the sliding table and adjust the two coach bolts (f), until the bubble on the level is between the two markers (g), tighten the three nuts (e) (See figs 62 & 63).





DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

Raise the spindle to the maximum height by unlocking the spindle moulder rise/fall locking handle and turning the spindle moulder rise/fall handle clockwise then lock in place. Using a 19mm spanner remove the bolt & clamping block **(D)**, spacing collar/s **(E)** and clamping washer **(F)** and place them safely aside, remove the cutter block. Check the new cutter block for damage,sharpness etc. Fit the new cutter block on the arbor as low as possible, see fig 1and 2. Watch the direction of rotation (counter-clockwise) when mounting the cutter. replace the clamping washer **(F)**, spacing collar/s **(E)**, clamping block **(D)** and bolt. Tighten the clamping block securely (See figs 64,65,66 &67).

Fig 64

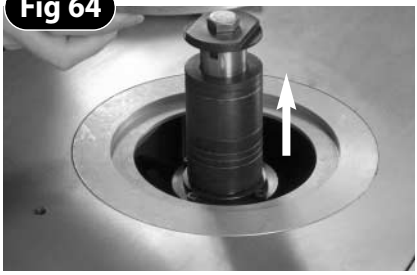


Fig 65

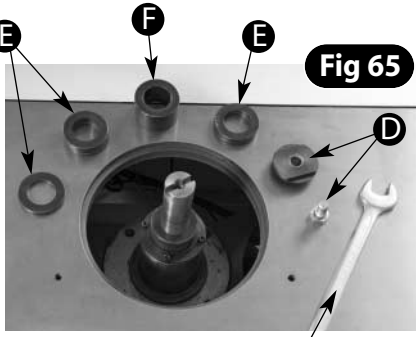


Fig 66

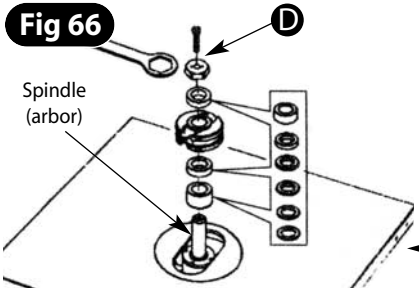
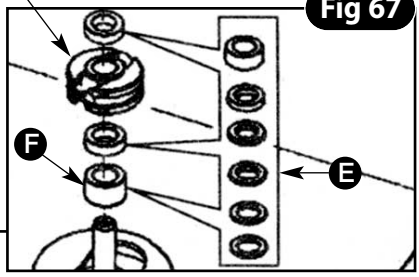


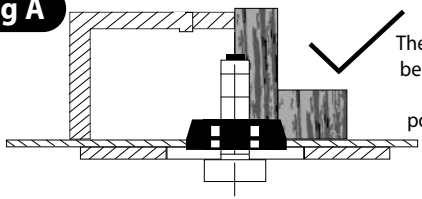
Fig 67



Changing the spindle moulder cutter

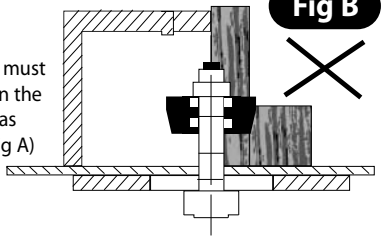
Turn the cutter block once by hand to check it doesn't foul anywhere. Reconnect the machine to the mains supply. Give the machine a 'quick' burst check **(i.e. quick ON-OFF)** to ensure everything is O.K. If everything is satisfactory, continue to use the machine. Check the old cutter block for damage, sharpness, resin buildup, etc., clean if necessary and send for refurbishment/resharpening if required. If the cutter block is not to be re-sharpened, clean and pack away in its stowage case.

Fig A



The cutter block must be positioned on the arbor as low as possible. (See fig A)

Fig B



DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

Open the motor access door to the front of the machine, by removing the two caphead screws, see figs 68 & 69, lower the spindle to it's lowest point, if not done so already. Locate the 10mm allen key (G), loosen the caphead bolt (H) on top of the motor, pull the motor tension lever (I) out, to allow the belt to go slack & reposition the belt on the pulleys as required. When you are happy push back the tension lever (I) and tighten the caphead bolt (H) to keep the tension (See figs 70,71 & 72).

Fig 68

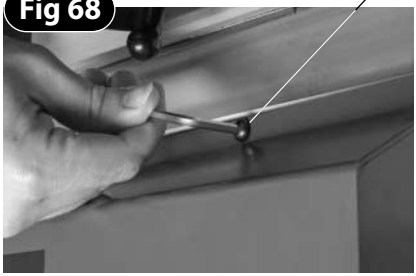


Fig 69

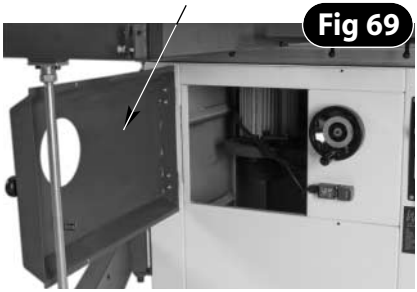


Fig 70

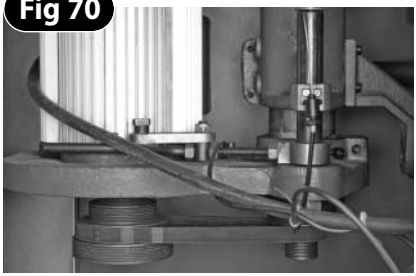


Fig 71

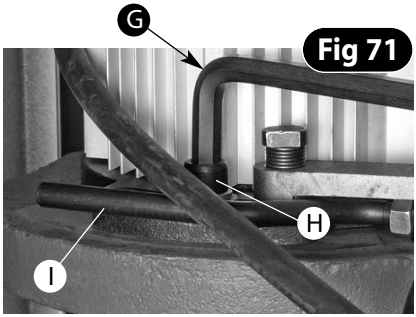
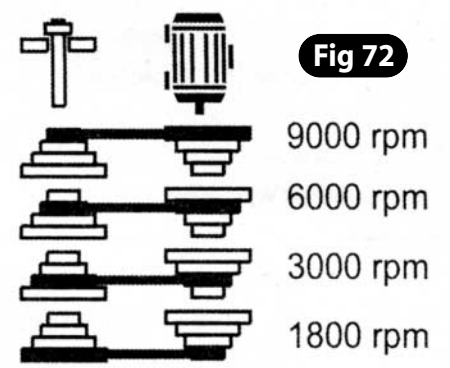


Fig 72

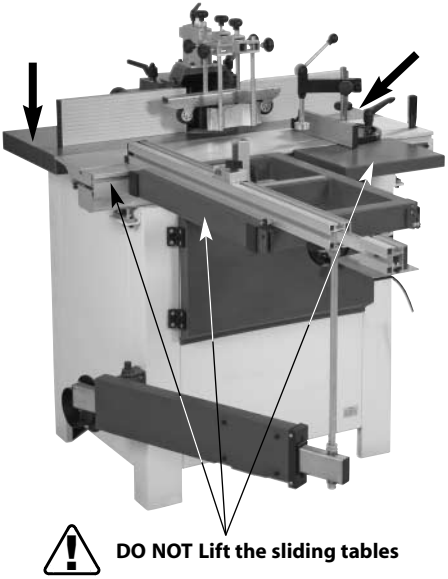


Speed Chart

Close the access door, raise the spindle, reconnect the machine to the mains supply. Give the machine a 'quick' burst check (i.e. quick ON-OFF) to ensure everything is O.K. If everything is satisfactory, continue to use the machine.

Positioning the Machine

Note: Ascertain the orientation of the machine and move it to its desired position in the workshop. Ensure that the machine is positioned to allow sufficient clearance both in front, behind and to the sides of the machine to cater for the maximum length of timber you will wish to machine. The machine should be positioned on a flat level surface. Once the machine is in position, and level, it can be bolted to the floor if so required.



DO NOT Lift the sliding tables

Max Weight

SAFETY WARNING!

The WS1000TA Spindle Moulder is a heavy piece of equipment. You are advised to seek help or the use of some form of lifting device, (hoist, engine crane etc.,) before you attempt to lift or move this machine.

Using a Sanding Drum

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

The spindle moulder can be used as a sander by attaching a sanding drum to the spindle, please follow the instruction below.

Warning: When using the sanding drum, the spindle speed should not exceed 1800 rpm.

•Raise the spindle to the maximum height by unlocking the spindle moulder rise/fall locking handle and turning the spindle moulder rise/fall handle clockwise then lock in place.

•Remove the spindle guard & guide assembly, place safely aside.

•Remove the cutter block as described on page 23, insert the sanding drum **(a)** into the sanding sleeve **(b)**.

• Place a spacing collar **(c)** & the sanding drum assembly onto the spindle, place a further spacing collar **(c)** on top sanding drum assembly. Secure using the clamping block **(d)** & bolt **(e)**, tighten with a 19mm spanner **(DO NOT OVERTIGHTEN)** (See fig 73).

Sanding drum assembly

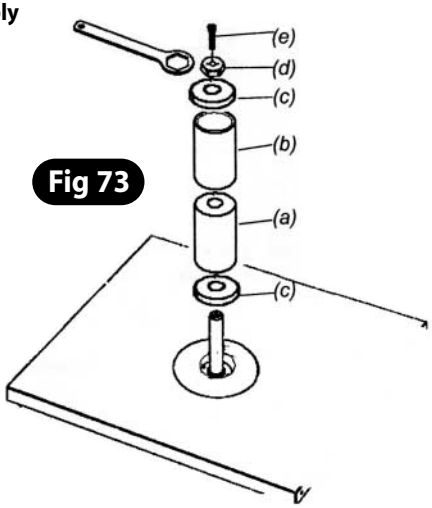


Fig 73

Workpiece Handling

•Feed the workpiece straight across the machine table, holding the fingers close together and guiding the workpiece with the palms of your hands.
•Never put your hands under or behind the cutter guard.
•Always keep your hands well clear of the rotating cutter.
•Always feed the workpiece against the cutter rotation as shown by the arrow in illustration.
•Use a push stick when working the ends of narrow stock.
•Use a feeding aid if you are going to machine a workpiece shorter than 300mm.
•Always machine the workpiece over its entire length.

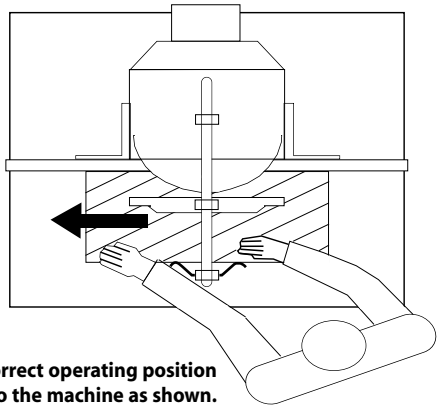
Recess machining may only be carried out with the aid of suitable longitudinal workpiece stops.

•When working complex shapes, make jigs and guides to guide the workpiece properly and safely.

•Make trial cuts on a piece of scrap before working the actual workpiece.

•Support long workpieces with roller stands or table extensions.

•Always work one workpiece at a time.



Correct operating position
Position yourself offset to the machine as shown.

The spindle moulder can be fitted with the following optional accessories:

• Sliding Table Extension Order No: 950505 See fig 74)

This accessory is a support table complete with a telescopic support arm. It clamps to the sliding table to provide extra support when machining panels or the ends of long boards. Supplied with a long fence arm and length stop. The telescopic arm requires mounting to the machines chassis using the mounting hole provided. Some care should be taken when mounting the arm to ensure that the table stays level throughout its travel.

• Tenon Plate Order No: 950506 (See fig 75)

This accessory is a simple alloy plate that lifts the work piece above the table. This means that you can machine the top and bottom surface of the work, such as when creating a tenon. It can be mounted next to the mitre fence and clamp so as to make the machining of end grain material as safe as possible.

•Co-Matic AF32 Junior Power Feed Order No: 340195 (See figs 76 & 77)

A medium weight power feed unit with three white rubber rollers, all spring-loaded to provide a constant feed rate on either a planer, saw bench or spindle moulder. There is a choice of four feed speeds, easily selectable by removing the side plate and re-positioning the drive gears. The horizontal and vertical position of the drive head can be precisely adjusted with the aid of the two adjusting screws and then securely locked in place with the two handles.

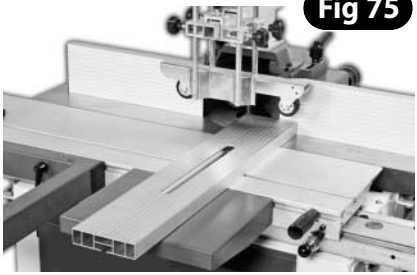
An additional feature is the ability to rotate the head through 90° so that pressure can be applied to the work in either the vertical or horizontal planes. The unit is secured to the table of the machine, either by bolting through or by screwing into holes tapped into the cast iron bed. If drilling the holes into the table of your machine is too disheartening then the purchase of the universal quick fix support plate (800430) is an excellent solution.

The plate bolts onto the corner of a table and is clamped in place with the bolts provided. The top of the plate is drilled and tapped to accept all of the power feed units we offer, allowing the unit to be bolted on to whichever machine it is required on.

Fig 74

Sliding Table Extension Assembly

Fig 75



Tenon Plate

Fig 76

Co-Matic AF32 Junior Power Feed in operation

Fig 77

Co-Matic AF32 Junior Power Feed

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

Spindle Moulder

• **Keep** the cutter block clean and free from dust build up.

• **Check** the cutter block regularly for chipped blades and damage to block i.e cracks in the cutter block.

• When changing the cutter block, remove the cutter block and place safely away, clean the spindle by spraying a light coating of oil over the shaft and install a new cutter block.

•Opening the access door for the spindle moulder, check the belt tension. If the belt is loose, using the 10mm allen key lossen the motor caphead bolt and push/pull until the belt is under tension again, tighten the motor bolt to keep the tension.

• If the "Spindle Moulder" is not going to be used for a period of time spray, a light coat of oil over the table service and blades, this will help prevent rust and place a dust sheet over the spindle moulder.

Major Service

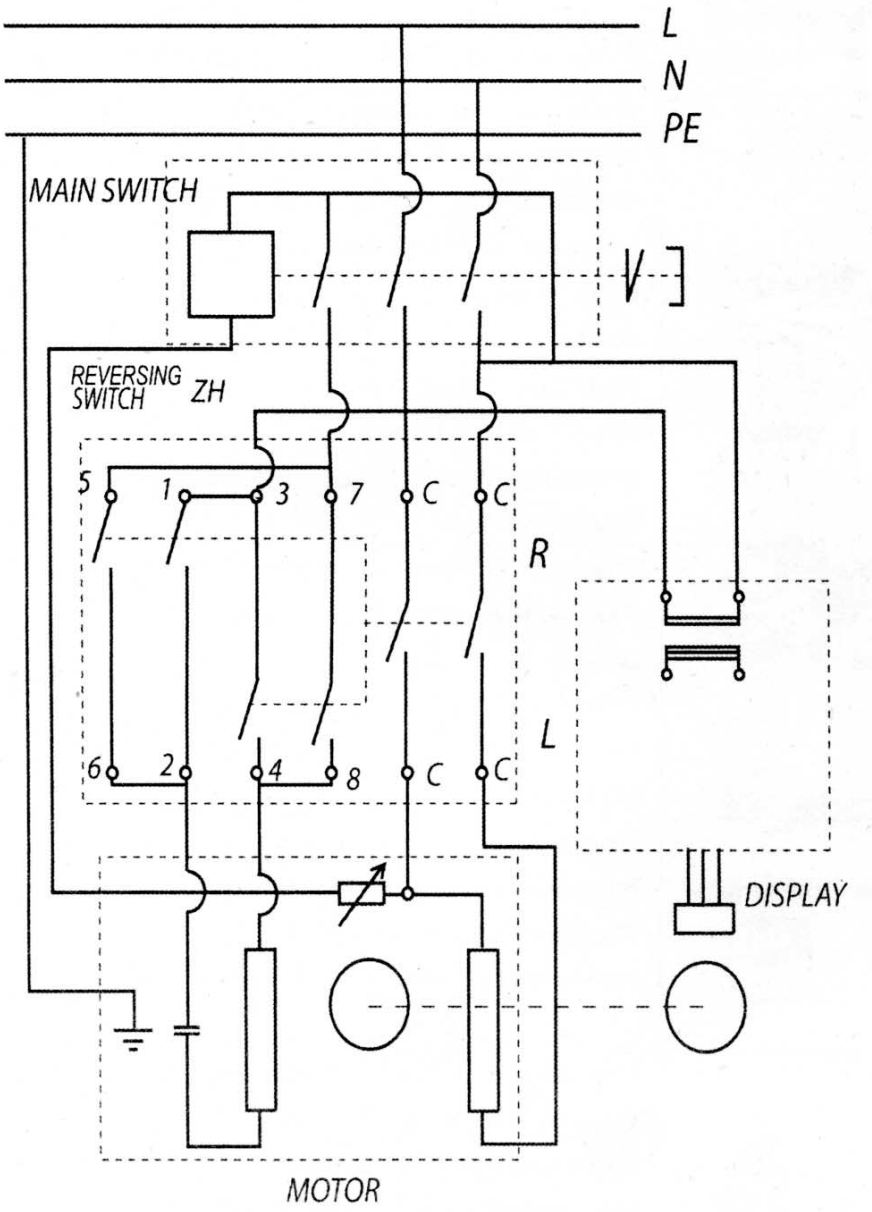
After several months of constant use the condition of the chains, sprockets and tension of the drive belts and the treaded drive shafts of the rise and fall tilt mechanisms will need to be checked, that will require a service engineer to see over the job. If you find that the machine is not performing as it should please contact "Axminster Tool Centre" by phone on 0800 371822.

DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

Trouble Shooting Guide

Problem	Cause	Solution
Motor is slow or weak	Voltage from source is low. Windings are burned out or open. Power Switch is defective. Circuit is overloaded with appliances, lights, or other electrically powered equipment.	Request a voltage check from local power company. Have the Motor checked / repaired. Have the Power Switch replaced. Do not use other appliances or electrically powered equipment on the same circuit when using the Machine.
Motor overheats.	Motor is overloaded. Blunt cutting tool.	Request a voltage check from the local power company. Replace the cutting tool.
When cutting, the cutter burns the work-piece, or stalls the motor.	Cutting tool is blunt. Work-piece is warped.	Sharpen or replace the cutting tool. Replace the work-piece.
Bevel & Height Handles are hard to turn.	Dust has collected on the mechanisms inside the base.	Clean and lubricate the mechanisms inside the base.
The spindle does not bevel or does not lower or raise.	Bevel Lock Handle is not fully released. Height Lock Handle is not fully released.	Fully release the Bevel Lock Handle. Fully release the height Lock Handle.
Spindle moulder vibrates excessively.	Floor surface is uneven. V-belt is damaged. Milling tool is damaged. Loose bolt. Screws, Nuts.	Raise up each leg until the machine is level. Replace the V-belt. Replace the cutting tool. Tighten all Screws, Nuts.
Spindle moulder does not start.	Motor Cord is not plugged in. Circuit fuse is blown. Circuit breaker is tripped. Motor Cord or Switch is damaged.	Plug in Motor Cord to volt electrical outlet. Replace circuit fuse. Reset circuit breaker. Have the Motor Cord or Switch replaced.
Power Switch does not operate.	Power Switch contacts are burned out. Capacitor is defective. Wiring connections are loose or damaged.	Have the Power Switch replaced. Request a voltage check from the local power company. Have the Capacitor replaced. Have the wiring connections checked/repaired.
Fuses or circuit breakers open frequently.	Motor is overloaded. Fuses or circuit breakers are wrong size or defective. Blunt cutting tool. Power Switch is defective.	Feed work-piece more slowly. Replace fuses or circuit breakers. Replace the cutting tool. Have the Power Switch replaced, (contact Axminster Tool Centre on **0800 371822**)
Motor stalls, blows fuses, or trips circuit breakers.	Motor is overloaded. Blunt cutting tool. Fuses or circuit breakers are wrong size or defective. Feeding work-piece too rapidly.	Request a voltage check from the local power company. Replace the cutting tool. Replace fuses or circuit breakers. Feed work-piece more slowly.
Spindle moulder is noisy when running.	Motor is loose or defective.	Have the Motor checked/repaired, (contact Axminster Tool Centre on **0800 371822**)

Warning: To prevent personal injury or damage to the spindle moulder, maintenance and repairs should be done only by a qualified technician (contact Axminster Power Tool Centre on 0800 371822).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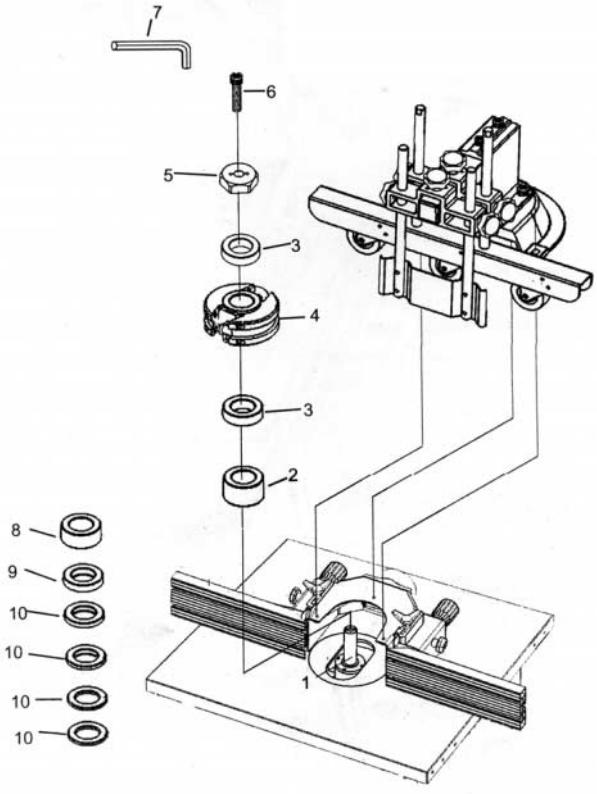
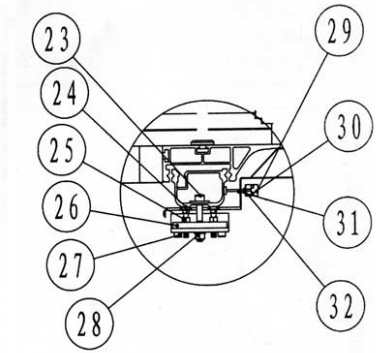
DISPLAY
MOTOR

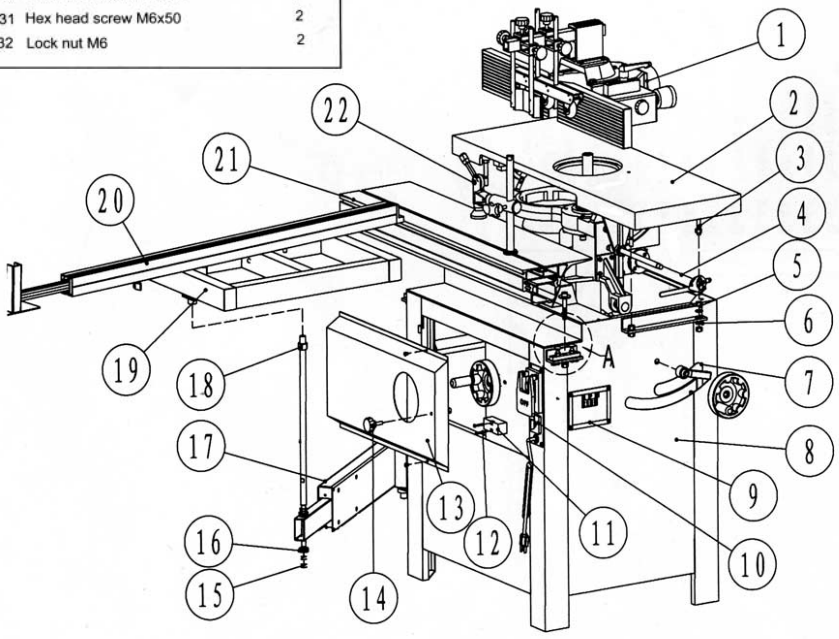
No.	DESCRIPTION	Q'ty
1	Spindle shaft	1
2	Spindle ring Φ50x30x30mm	1
3	Spindle ring Φ50x30x10mm	1
4	Cutting tool	1
5	Lock flange	1
6	Allen bolt M12x25	1
7	Allen wrench 10mm	1

No.	DESCRIPTION	Q'ty
8	Spindle ring Φ50x30x20mm	1
9	Spindle ring Φ50x30x10mm	1
10	Spindle ring Φ50x30x5mm	4



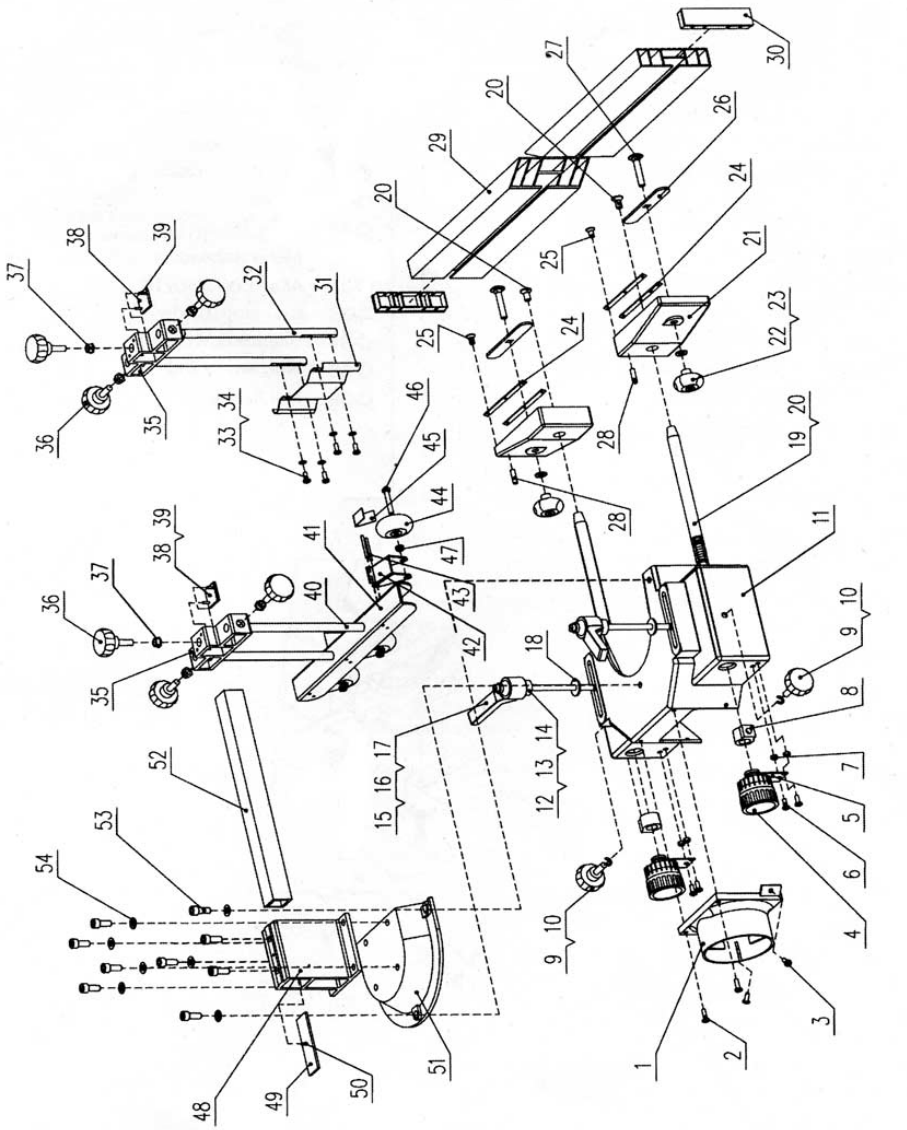
No.	DESCRIPTION	Q'ty
A-1	Safer guard	1
A-2	Table	1
A-3	Allen bolt M10x70	4
A-4	Mill drive set	1
A-5	Lock nut M10	12
A-6	Flat washer 10mm	8
A-7	Scutcheon	1
A-8	Workstand	1
A-9	Spindle height display	1
A-10	Main switch (No-volt release)	1
A-11	Switch(QKS8)	1
A-12	Cross recessed pan head screw M4x30	2
A-13	Left panel, machine housing	1
A-14	Startype screw M8x15	1
A-15	Lock nut M12	4
A-16	Thrust bearing 8101	2
A-17	Swing arm	1
A-18	Lock nut M16	1
A-19	Sliding bench (optional)	1
A-20	Guide rail	1
A-21	Sliding rail	1
A-22	Workplece	1
A-23	Allen bolt M12x65	2
A-24	Carriage bolt, M8x45	2
A-25	Lock nut M8	4
A-26	Guide, bolt	2
A-27	Allen bolt M8x16	4
A-28	Lock nut M12	2
A-29	End stop, guide	2
A-30	Hex head screw M5x16	4
A-31	Hex head screw M6x50	2
A-32	Lock nut M6	2





No.	DESCRIPTION	Q'ty
B-1	Dust outlet	1
B-2	Cross recessed pan head screw M5x12	2
B-3	Cross recessed pan head screw M5x16	2
B-4	Setting knob, spindle latch	2
B-5	Lock piece, handle	2
B-6	Hex head screw M5x16	4
B-7	Hex nut M5	4
B-8	Lock spacer	2
B-9	Flower screw M8x25	2
B-10	Hex nut	2
B-11	Safer guard	1
B-12	Rachet lever	2
B-13	Lock cover	1
B-14	Roll pin 4x16	2
B-15	Starknob	2
B-16	Spring	2
B-17	Screw	2
B-18	Flat washer 8mm	2
B-19	Guide spindle, spindle latch	2
B-20	Countrsunk head screw M8x20	2
B-21	Fence extrusion carriage	2
B-22	Flower nut	2
B-23	Flat washer 8mm	2
B-24	Batten	2
B-25	Countrsunk head screw M5X10	12
B-26	Guide, bolt	2
B-27	Carriage bolt, M8x40	2

No.	DESCRIPTION	Q'ty
B-28	Lock screw M6X20	8
B-29	Fence extrusion	2
B-30	End cap,fence	2
B-31	Plate, anti-kickback	1
B-32	Rod, roller	2
B-33	Flat washer 5mm	4
B-34	Cross recessed pan head screw M5x12	4
B-35	Feed arm	2
B-36	Starknob	6
B-37	Hex nut	6
B-38	Insert, feed arm	2
B-39	Roll pin 3X10	4
B-40	Rod, roller	2
B-41	Roller frame	1
B-42	Roller house	3
B-43	Roll pin 4X35	6
B-44	Roller	3
B-45	Plate spring	3
B-46	Hex head screw M6X35	3
B-47	Lock nut M6	3
B-48	Feeder base	1
B-49	Block,feeder base	1
B-50	Roll pin 3X10	1
B-51	Cover, safer guard	1
B-52	Feeder arm	1
B-53	Allen bolt M8x20	9
B-54	Flat washer 8mm	7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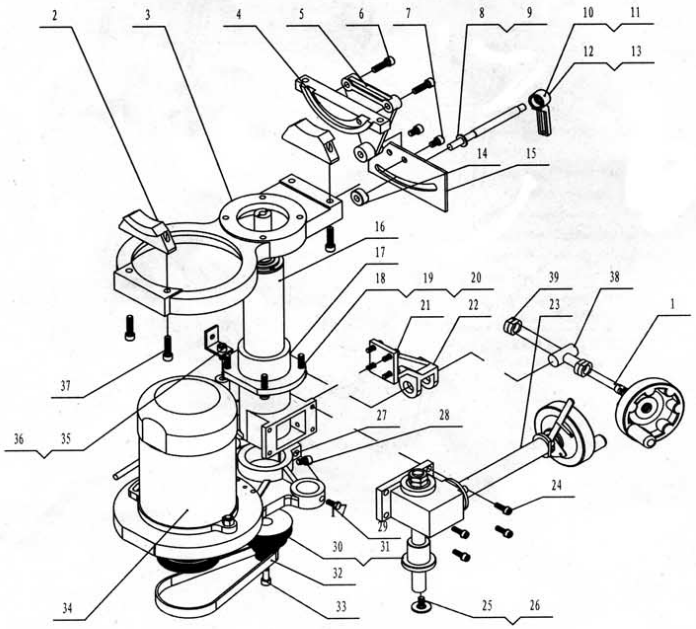
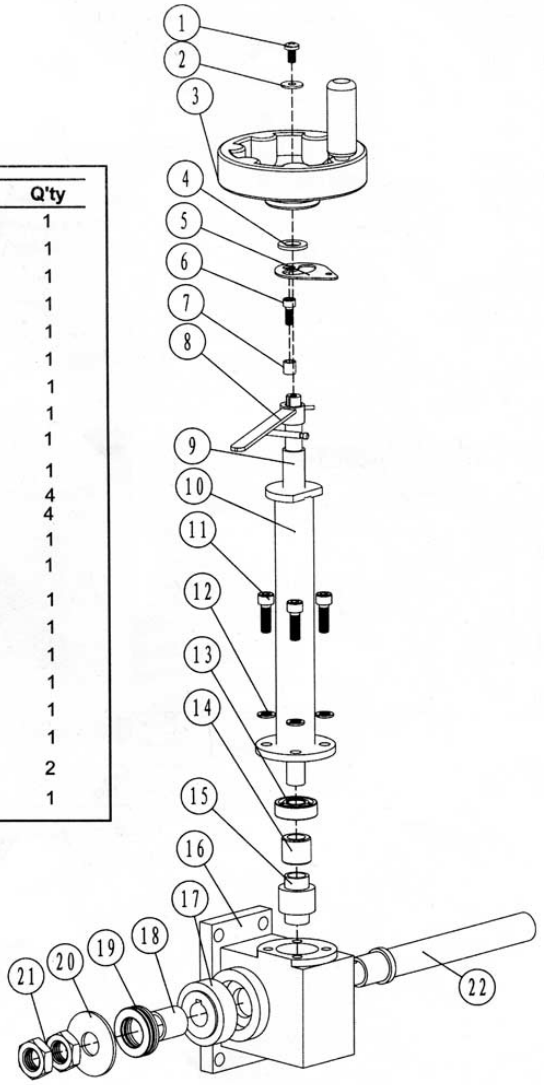
No.	DESCRIPTION	Q'ty
C-1	Tilting set	1
C-2	Support, swivel turnion	2
C-3	Swivel guide	1
C-4	Swivel, turnion	2
C-5	Lockup seat	1
C-6	Allen bolt M10x35	2
C-7	Allen bolt M8x16	2
C-8	Flat washer 12mm	1
C-9	Lockup shaft	1
C-10	Tilt locking lever	1
C-14	Tilt locking block	1
C-15	Lockup seat	1
C-16	Spindle shaft set	1
C-17	Swivel head	1
C-18	Allen bolt M10x35	4
C-19	Spring washer 10mm	4
C-20	Flat washer 10mm	4
C-21	Allen bolt M6x20	4

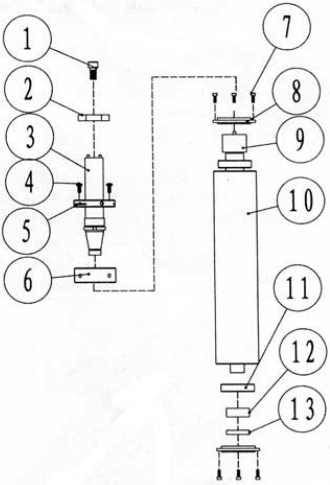
No.	DESCRIPTION	Q'ty
C-22	Joint, swivel rod	1
C-23	Elevator	1
C-24	Allen bolt M8x20	4
C-25	Allen bolt M10x16	1
C-26	Big flat washer 10mm	1
C-27	Allen bolt M12x30	1
C-28	Allen bolt M8x20	2
C-29	Hex head screw M8x16	1
C-30	Spindle pulley	1
C-31	Flat key 8x8x25	1
C-32	V-belt	1
C-33	Allen bolt M10x45	1
C-34	Motor set	1
C-35	Allen bolt M10x16	1
C-36	End stop, guide	1
C-37	Allen bolt M10x45	4
C-38	Nut, swivel rod	1
C-39	Nut,fix rod	4



No.	DESCRIPTION	Q'ty
D-1	Countersunk head screw M5x12	1
D-2	Large washer 6mm	1
D-3	Wheelhandle	1
D-4	Large washer 12mm	1
D-5	Pear plate, lock lever	1
D-6	Allen bolt M6x25	1
D-7	Bushing, pointer	1
D-8	Lock lever, rise	1
D-9	Rise shaft	1
D-10	Housing, rise shaft	1
D-11	Allen bolt M8x25	4
D-12	Spring washer 8mm	4
D-13	Ball bearing 80202	1
D-14	Bushing,worm	1
D-15	Worm	1
D-16	Carrier, rise gear	1
D-17	Gear-helical	1
D-18	Bushing, spindle	1
D-19	Thrust bearing 8105	1
D-20	Special washer	1
D-21	Thin hex nut M20	2
D-22	Rising spindle	1

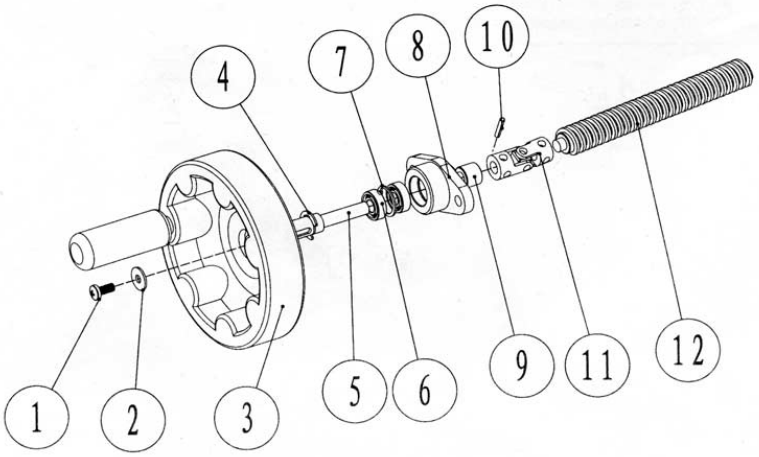


No.	DESCRIPTION	Q'ty
E-1	Allen bolt M12x25	1
E-2	Lock flange	1
E-3	Spindle shaft A	1
E-4	Cross recessed pan head screw M5x10	2
E-5	Lock nut A	1
E-6	Lock nut B	1
E-7	Allen bolt M5x16	8
E-8	Cup, Spindle guide tube	2
E-9	Spindle shaft B	1
E-10	Spindle guide tube	1
E-11	Ball bearing 80106	2
E-12	Lock nut M30	1
E-13	Lock nut M30	1



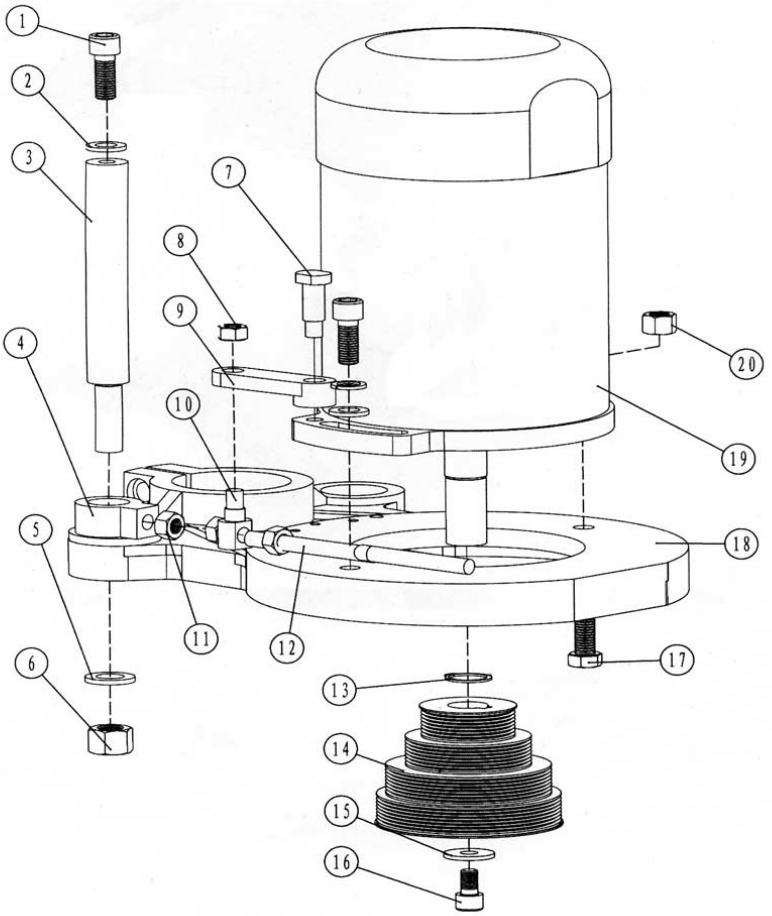
No.	DESCRIPTION	Q'ty
F-1	Countersunk head screw M5x12	1
F-2	Large washer 6mm	1
F-3	Wheelhandle	1
F-4	Circle 9mm	1
F-5	Pin, cone gear	1
F-6	Ball bearing 619/8	2

No.	DESCRIPTION	Q'ty
F-7	Circle 19mm	1
F-8	Gear base	1
F-9	Bushing,worm	1
F-10	Roll pin 3x16	1
F-11	Gimbal	1
F-12	Swivel rod	1

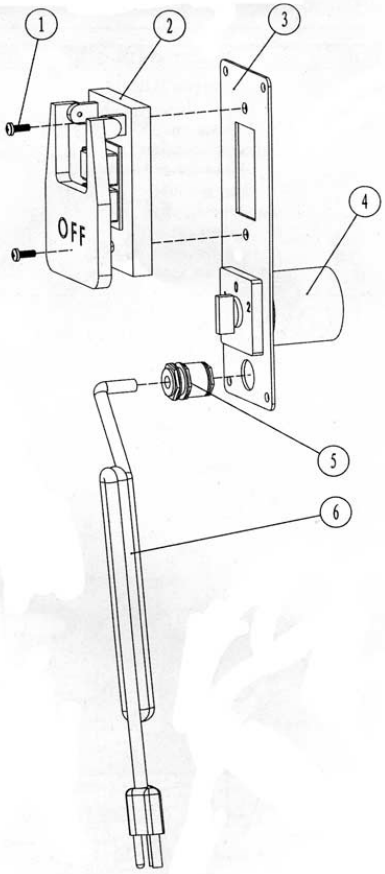


No.	DESCRIPTION	Q'ty
G-1	Allen bolt M10x15	1
G-2	Flat washer 10mm	1
G-3	Guide bar	1
G-4	Joint, tension	1
G-5	Flat washer 16mm	1
G-6	Hex nut m16	1
G-7	Thread, joint	1
G-8	Lock nut M10	1
G-9	Joint, motor tension	1
G-10	Thread, tension	1

No.	DESCRIPTION	Q'ty
G-11	Lock nut M10	3
G-12	Lever, tension	1
G-13	Circle 24mm	1
G-14	Motor pulley	1
G-15	Large washer 10mm	1
G-16	Allen bolt M10x20	1
G-17	Hex head screw M12x40	1
G-18	Mount, motor	1
G-19	Motor	1
G-20	Hex nut M12	1

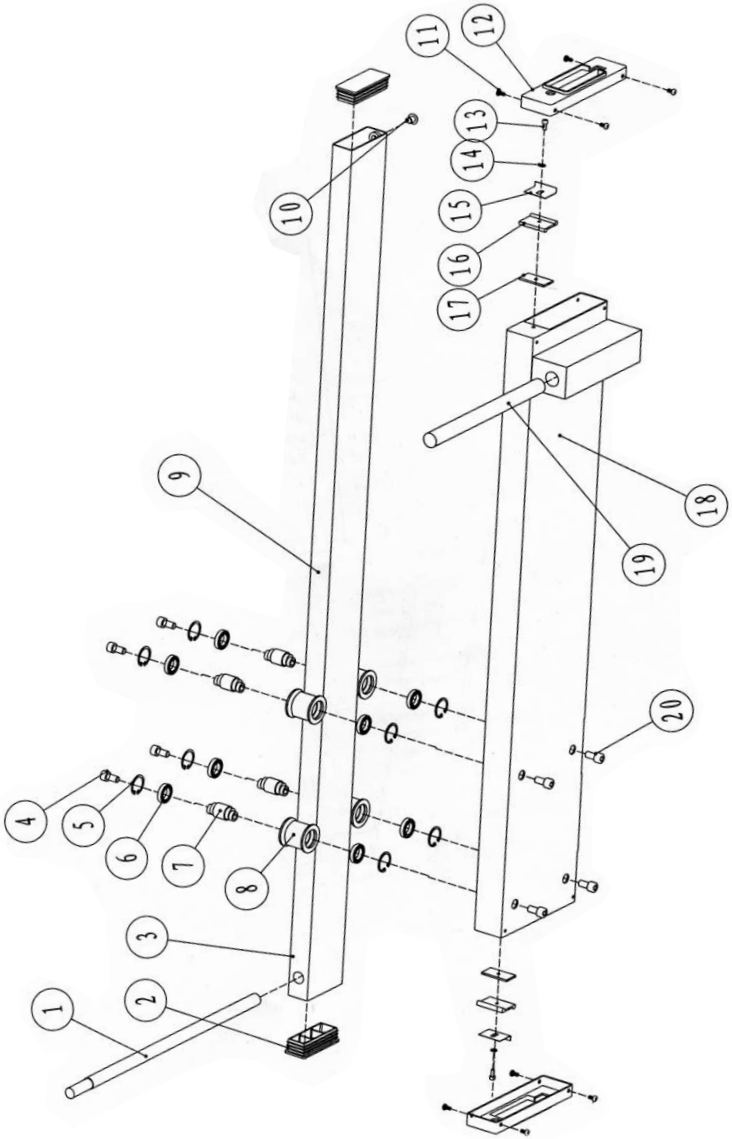


No.	DESCRIPTION	Q'ty
H-1	Cross recessed pan head screw M4x12	2
H-2	Switch KJD17B-16	1
H-3	Switch Batten	1
H-4	ZH-HC-3	1
H-5	Nut M20	1
H-6	Electrical wire	1



No.	DESCRIPTION	Q'ty
I-1	Guide bar	1
I-2	End cap	2
I-3	Telescopic arm	1
I-4	Allen bolt M6x12	4
I-5	Circle 24mm	8
I-6	Ball bearing 61901	8
I-7	Partiality shalf	4
I-8	Wheel	4
I-9	Telescopic arm	1
I-10	Allen bolt M6x12	1

No.	DESCRIPTION	Q'ty
I-11	Cross recessed pan head screw M5x12	8
I-12	End cap	2
I-13	Allen bolt M6x12	1
I-14	washer 6mm	1
I-15	Guide, bolt A	1
I-16	Guide, bolt B	1
I-17	Guide, bolt C	1
I-18	Swing arm	1
I-19	Guide bar	1
I-20	Allen bolt M6x12	1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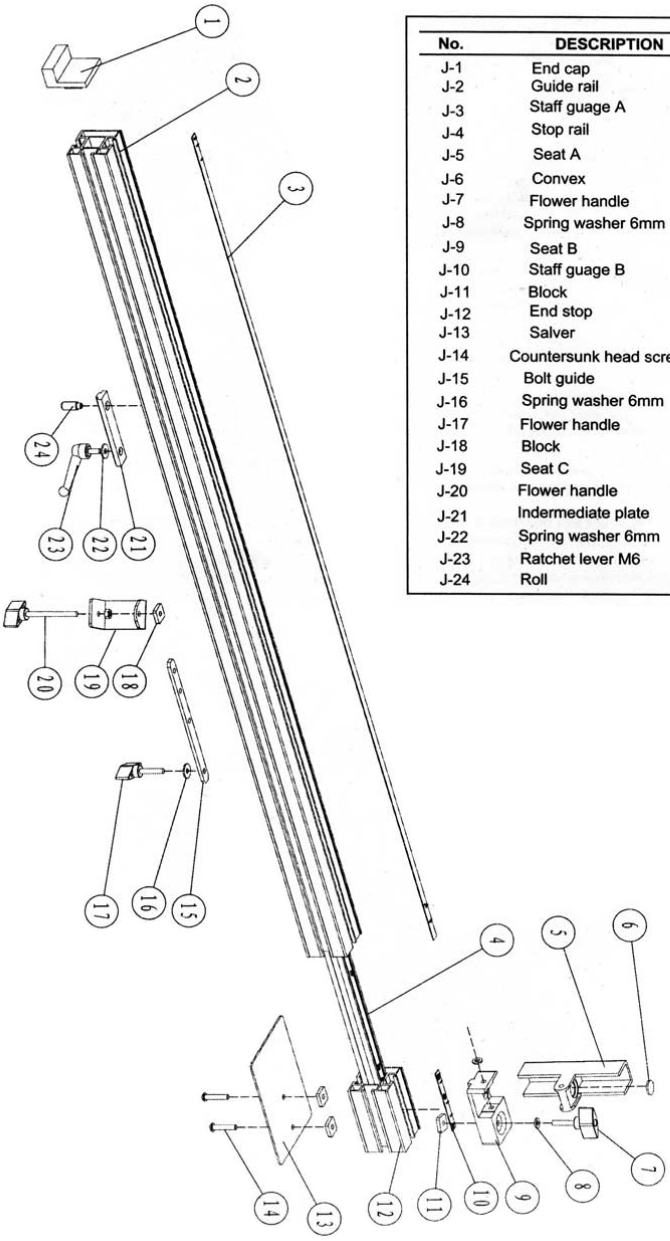
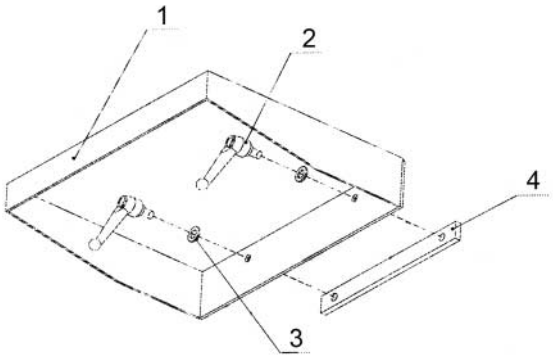
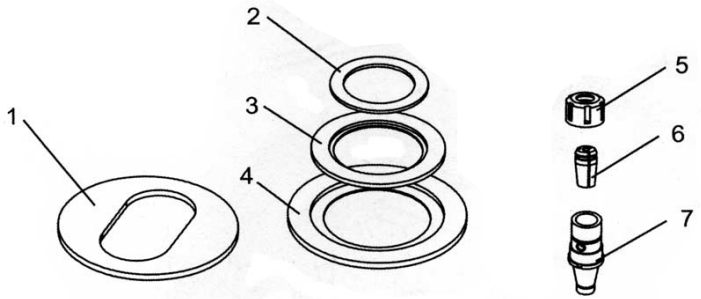


No.	DESCRIPTION	Q'ty
J-1	End cap	1
J-2	Guide rail	1
J-3	Staff guage A	1
J-4	Stop rail	1
J-5	Seat A	1
J-6	Convex	1
J-7	Flower handle	1
J-8	Spring washer 6mm	1
J-9	Seat B	1
J-10	Staff guage B	1
J-11	Block	1
J-12	End stop	1
J-13	Salver	1
J-14	Countersunk head screw M6x30	2
J-15	Bolt guide	1
J-16	Spring washer 6mm	1
J-17	Flower handle	1
J-18	Block	1
J-19	Seat C	1
J-20	Flower handle	1
J-21	Indermediate plate	1
J-22	Spring washer 6mm	1
J-23	Ratchet lever M6	1
J-24	Roll	1



No.	DESCRIPTION	Q'ty
K-1	Sliding bench	1
K-2	Tilt lock	2
K-3	Spring washer 6mm	2
K-4	Bolt guide	1



No.	DESCRIPTION	Q'ty
L-1	Table ring 200mm for tilt	1
L-2	Table ring 110/80mm	1
L-3	Table ring 150/110mm	2
L-4	Table ring 200/150mm	1
L-5	Flange	1
L-6	Collet	1
L-7	Spindle shaft	1

Please dispose of packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local recycling centre and place into the appropriate recycling bin.

Only for EU countries

Do not dispose of electric tools together with household waste material. In observance of European Directive 2002/96/EC on waste electrical and electronic equipment and its implementation in accordance with national law, electric tools that have reached the end of their life must be collected separately and returned to an environmentally compatible recycling facility.